STUDY THE EFFECT OF CO₂ MAG WELDING PROCESS PARAMETERS ON THE HEAT INPUT AND JOINT GEOMETRY DIMENSIONS USING EXPERIMENTAL AND COMPUTATIONAL METHODS

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ABSTRACT: In this paper, predicted models for heat input and joint geometry dimensions after CO₂- MAG welding process have been developed. Before welding, steel specimens were first prepared and then butt welded using electrode wire melted and supplied into the molten pool by applying heat input continuously. Weld bead dimensions were first measured, and then the results were analyzed to check the adequacy of the models by Response Surface Method using DOE technique. These models were found capable of predicting the optimum performance dimensions required for the joint geometry in terms of weld bead width, reinforcement height and penetration. The obtained results indicated that the heat input depends on voltage, wire feed speed and gas flow rate, while for the weld bead dimensions; the gas flow rate has less effect. A comparison between the experimental and predicted results was made, and a good agreement was found between them.

Keywords: Low Carbon Steel, CO2-MAG Process, Heat input, Joint Geometry, Modeling, Experimental and Computational Methods, Optimization.

1. INTRODUCTION

CO₂-MAG is an arc welding process where heat is generated for arc between the workpiece and a consumable metal electrode with an externally supplied gaseous shield of gas either inert, such as CO₂. It is a versatile process, gives very little loss of alloying elements and can be operated as semi as well as fully automated. A bare solid wire called electrode is continuously fed to the weld zone, it becomes filler metal as it is consumed. Electrical energy is supplied from the welding generator for melting wire and workpiece to be welded. The weld is made by falling successive drops on the weld puddle. The arc and the molten puddle are protected from contamination by the atmosphere (i.e., oxygen and
CO₂ gas is an odorless, colorless gas with a slightly pungent, acid taste and slightly toxic. Differing from other reactive gases such as oxygen, CO₂ can be used alone for GMAW shielding gas applications. Pure CO₂ is the cheapest of the shielding gases and can be used as a shield for welding steel up to 0.4% C and low-alloy steel. All the major commercial metals can be welded by the process CO₂-MAG, including carbon steels, stainless steels, aluminum, copper, titanium. Because there is some dissociation of the CO₂ in the arc resulting in carbon monoxide and oxygen being formed, the filler wire is triple deoxidized to prevent porosity, and this adds somewhat to its cost and results in some small areas of slag being present in the finished weld.

Gas flow rate can greatly affect the quality of the weld, since too low a flow rate gives inadequate gas shielding and leads to the inclusion of oxides and nitrides, while too high flow rate can introduce a turbulent flow of the CO₂ which occurs at a lower rate than with argon. This affects the efficiency of the shield and leads to a porosity in the weld. Also, gas flow rate, which can range from a few cubic feet per hour (cfh) to more than 60 cfh, depends on the current developed, the torch size, the shielding gas composition and the surrounding environment (drafts, etc.). In general, a higher current will require a larger torch and higher flow rates. In addition, gas density, or the weight of the gas relative to air, has a major influence on the minimum flow rate required to effectively shield the weld.

Welding with the recommended heat input results in good mechanical properties in the heat affected zone (HAZ). The heat supplied by the welding process affects the mechanical properties of the welded joint. Heat input can be referred to as "the electrical energy supplied by the welding arc to the workpiece. The most important characteristic of heat input is that it governs the cooling rates in welds and thereby affects the microstructure of the weld metal and the heat affected zone. A change in microstructure directly affects the mechanical properties of welds. Therefore, the control of heat input is very important in arc welding in terms of quality control.

Quality of the welded joint in CO₂-MAG welding process depends on number of parameters, like type and thickness of base metal, design type, welding position, etc., but the proper selection of welding parameters is also very important. Due to that, the weld bead geometry in CO₂-MAG welding process and heat input with regard to weld voltage, wire feeding speed and gas flow rate were experimentally investigated in the present work, since the proper selection of gas flow and heat input will provide a weld joint with satisfactory geometrical characteristics.
A large amount of research works have been carried out to find out the most suitable combination of input process parameters for a desired output using different welding processes and various computer software as tools for modeling and optimization the weld bead geometry, such as Taguchi (6), Artificial neural networks (ANN) (7), and Response surface methodology (RSM) (8). Das et al. (9) studied the effect of arc voltage, current and welding speed on the weld joint geometry, while Shoeb et al. (10) considered also the influence of gas flow rate. In addition, Patel and Patel (11) investigated also the wire diameter and wire feed rate during CO₂-MAG welding process. But, there is a little work about modeling and computational optimization of the closed butt weld bead geometry by using Design of Experiment (DOE) with (RSM) technique to predict mathematical models that can be used to obtain the optimum responses for any given input parameters. Therefore, the aim of this paper is to study the influence of main welding parameters (voltage, wire feeding speed and gas flow rate) on the heat input and final weld pool geometry during CO₂-MAG welding using DOE and RSM method.

2. EXPERIMENTAL PROCEDURES

2.1 Material and Specimens Preparation

The material used in the present work is low carbon steel (LCS) plate with 5 mm thickness in the hot rolled condition. This material was chemically analyzed in State Company for Inspection and Engineering Rehabilitation (SIER) in Baghdad, and its chemical composition is given in Table (1), showing that the experimental material conforms to the standard low carbon steel type AISI 1010 (12). The plate was cut to provide specimens with size 50 mm × 25 mm × 5 mm to be welded in a closed Butt weld joint design by CO₂-MAG process. Specimens from the as-received material were tensile tested according to ASTM E8 in Strength Laboratory / University of Technology-Baghdad, and the results are given in Table (2). The results in this table represent the average of three readings (three samples).

2.2 Selection of Welding Parameters

Despite the use of CO₂-MAG welding process is influenced by number of Parameters, three of them were only selected in this investigation: voltage, wire feeding speed and gas flow rate in two levels (input parameters), as shown in Table (3). These parameters were chosen according to the capacity of CO₂-MAG welding machine and practical experience of the welder skill.

2.3 Welding Procedure

Twenty specimens were welded by CO₂-MAG process at different values of voltage, wire feeding speed and gas flow rate according to design matrix established by Design of
Experiment Version 8 Software as given in Table (4). The experiments were performed in random manner to avoid any systematic error. The welding machine type ‘INVERTER CO2 MAG - BEAM-350’ was used for welding the specimens in Korea-Iraq Vocational Training Center in Baghdad, with wire a filler type ‘AWS ER70S-6’ 1.2 mm diameter which is specifically used for welding low carbon steel. The welding machine set up is shown in Fig. (1) together with the specimens before and after welding process.

2.4 Measurements of Joint Geometry Dimensions

After each welding test, the weldment were cut, sectioned, ground, polished and finally etched to see the profile of the joint geometry with necessary dimensions for measuring purpose, which is schematically similar to that was shown in reference (13), see Fig. (2). The weld joint geometry dimensions in terms of bead width, reinforcement height and bead penetration were measured after sectioning all specimens by using a digital caliper with accuracy ± 0.01 mm. The results of measurements for these three dimensions as responses are also listed in Table (4).

Since the heat input parameter has a significant effect on the quality of the joint geometry, therefore it was decided to calculate the values of heat input for all weldments by using the following equation (4):

$$Q = \frac{\eta \cdot V \cdot I \cdot 60}{S \cdot 1000}$$  \hspace{1cm} (1)

Where, $Q$ = Heat input (kJ/mm), $V$ = Voltage (volt), $I$ = Current (Amp.) $S$ = Welding speed (mm/min) and $\eta$ = Thermal efficiency.

For modeling and optimization the heat input at the same levels of used voltage, wire feed speed and gas flow rate, the current reading was taken during the welding process from the machine. Also, the welding speed was calculated for each test. Therefore, the heat input value was calculated for each welding test taking into account that the thermal efficiency is equal to 0.8 for MAG welding type (5). The results of calculated welding speed and heat input are listed in Table (5).

3. RESULTS & DISCUSSION

The response surface methodology was achieved using the Design of Expert version 8 software to determine the predicted models for the dimensions of the weld joint geometry (bead width, reinforcement height and depth of penetration), as responses in terms of the selected input parameters (arc voltage, wire feeding speed and gas flow rate). The analyses of variance (ANOVA) for RSM reduced quadratic models were determined for the bead dimensions as given in Tables (6, 7, and 8). The results in these tables showed that the voltage (A) and wire feeding speed (B) are statistically significant, since their P-values were...
very small (< 0.5). This means that these two parameters contributed the highest effect on the weld joint geometry, while the gas flow rate has no influence on the bead width and reinforcement height [Tables (6 and 7)], since the gas flow rate term (C) is not in the model, except that it affects the penetration depth due to the appearance of this term in the model, as shown in Table (8).

The ANOVA analyses also pointed out that the quadratic effect was useful to incorporate into bead width and reinforcement models, since the second order terms were highly significant with a P-value lower than 0.05. In addition, it was noticed in Table (8) that the interaction (AB) of voltage and wire feeding speed and the interaction (BC) of wire speed rate and gas flow rate have the greatest impact on the weld penetration. Moreover, because the lack of fit was insignificant (P-value > 0.05) in Tables (6, 7 and 8), these three models are adequate and significant at 95% confidence. So, the final predicted equations for the weld geometry dimensions in terms of the actual input factors are:

**Bead width** = -447.67946 + 41.63455 * Voltage + 0.36693 * Wire feeding speed - 1.01179 * Voltage^2 - 1.07286E-003 * Wire feeding speed^2  

**Bead reinforcement height** = +117.50250 - 9.62500 * Voltage - 0.19505 * Wire feeding speed + 5.70000E-003 * Voltage * Wire feeding speed + 0.21063 * Voltage^2 + 2.63000E-004 * Wire feeding speed^2  

**Bead Penetration** = +17.22963 - 1.56938 * Voltage - 0.081675 * Wire feeding speed + 1.49031*Gas flow rate + 9.85000E-003 * Voltage * Wire feeding speed - 0.010525 * Wire feeding speed * Gas flow rate  

After the models were established, checking the adequacy of each model was conducted to examine the predicted model. Two types of model diagnostics, the normal probability plot and residuals versus the actual values plot, were used for verification, as shown in Figs. (3 and 4) for bead width. It can be seen from these plots that there was no violation of the normality assumption, since the normal probability plot followed a straight line pattern, the residual was normally distributed, and as long as the residual versus the predicted values show no unusual pattern and no outliers. Similar trends were observed in the plots related to the reinforcement and penetration models. Also, these three models showed a good agreement between the predicted and actual values for bead width, reinforcement height and penetration, as depicted in Fig. (5).

In order to see all input factors on one plot to provide silhouette views of the response surfaces, it helps to view the perturbation of the predicted responses caused by changing only one factor at a time from the center point of the experimental region. In other words, for response surface designs, the perturbation plot shows how the response changes as each
factor moves from the chosen reference point (at the middle of the design space), with all other factors held constant at the reference value. Accordingly, the perturbation plots for these three models are illustrated in Fig. (6). So, this figure indicates that, individually, both voltage and wire feeding speed largely affect the bead width and reinforcement, but they have a slight influence on the penetration. This is likely due to the higher heat input that increased the fusion of the material at the top surface of the joint. While, the gas flow rate has no effect on the bead width and reinforcement but slightly affect the penetration and this is may be due to the chemical affinity of the CO\textsubscript{2} gas with the molten material of the joint.

Since the diagnosis of the residuals reveals no statistical problems with the models, so the design of experiment generates the response surface plots in form of 2D contour, 3D surface and cube plots. Figures (7 and 8) show the 2D contour plots for the bead width and reinforcement, respectively as a function of voltage and wire feeding speed at gas flow rate of 10 L/min. It was found that welding at a gas flow rate of 8 and 12 L/min had no effect on these responses. It can be noticed from Fig.(7) that increasing both voltage and wire feeding speed increases the bead width due to the increase of quantity of the molten material that resulted by the increasing of the thermal input. Also, Fig. (8) shows that the increase of both voltage and wire speed decreases the reinforcement height, and this could be due to the higher fluidity effect of the molten material with increasing heat input.

Regarding the penetration model, Fig. (9) manifests the 3D surface plot for the weld penetration as a function of voltage and wire feeding speed at different gas flow rates. This figure depicts that all input parameters are effective in this model and have a slight increase on the bead penetration. However, the CO\textsubscript{2} gas is more effective than the other parameters at gas flow rate 8 L/min, Fig. (9a) due to the occurrence of higher penetration. And, this is attributed to the less chemical reaction of this gas with the molten material of the joint at this lower flow rate. Eventually, these observations are confirmed by the cube plot for penetration, as shown in Fig. (9d).

### 3.2 Modeling of Heat Input

Similarly for the heat input, the analysis of variance (ANOVA) for response quadratic model was constructed by DOE software as given in Table (9). This table shows that the input parameters as individual in addition to the quadratic terms of wire feeding speed and gas flow rate are all statistically significant and have the greatest influence on the heat input response according to their P-values (< 0.05). The lack of fit test indicates a good model, since it is insignificant with P-value greater than 0.05. So, this analysis indicates that this model is significant at 95% confidence. Also, this model showed a good agreement between
the predicted and actual values for heat input, as depicted in Fig. (10). so, the final predicted equation for the heat input in terms of the actual input factors is:

\[
\text{Heat input} = -7.06339 - 0.090188 \times \text{Voltage} + 0.080047 \times \text{Wire feeding speed} + 0.74389 \\
\times \text{Gas flow rate} - 2.42014E-004 \times \text{Wire feeding speed}^2 - 0.039065 \times \text{Gas flow rate}^2. \quad (5)
\]

In order to diagnose the statistical properties of this model, it was found that the residuals that falling on a straight line implying errors are normally distributed. Also, the residuals versus predicted actual for heat input data exhibited no obvious pattern or unusual structure implying models are accurate.

To gain perspective on the model, it is necessary to present the perturbation of the predicted response resulted by varying only one parameter at a time from the center point of the investigated region. Fig. (11) demonstrates the perturbation plot for the heat input model, indicating that, individually, all input parameters affect the heat input response. The wire feeding speed largely increased the heat input because of more molten material accumulated in the weld joint at higher feeding speed, whereas both voltage and gas flow rate slightly reduced the heat input due to the higher wire speed and higher and more chemical reaction of CO2 gas with the higher accumulated molten metal at the weld joint.

Because the diagnosis of the residuals manifested no statistical problems, the response surface plots were generated in terms of 3D surface plot, since all input parameters are significant in this model. Fig. (12) Depicts the 3D surface plot for the heat input response as a function of voltage and wire feeding speed at various gas flow rates. This figure shows the wire feeding speed is more effective on the heat input response at 10 L/min gas flow rate [Fig. (12b)] because of the higher molten material accumulated in the weld joint at higher feeding speed. Whereas both voltage and gas flow rate have a slight influence on heat input, and this is possibly ascribed to the higher wire speed and more chemical reaction of CO2 with the more accumulated molten material in the weld joint. Finally, these observations are confirmed by the cube plot for penetration, as shown in Fig. (12d) for the heat input response.

### 3.3 Computational Optimization

A computational optimization method was used in this work by selecting the desired goals for each factor and response. This computational optimization is provided by the Design of Experiment software to find out the optimum combinations of parameters in order to fulfill the requirements as desired. Therefore, this software used for the optimization purpose; based on the data from the predictive models for four responses, weld bead width, reinforcement height, penetration and heat input as a function of three factors: arc voltage, wire feeding speed and gas flow rate.
The computational optimization process involves combining the goals into an overall desirability function. To develop the new predicted models, a new objective function, named ‘Desirability’ which allows to properly combining all the goals, was evaluated. Desirability is an objective function, to be maximized through a computational optimization, which ranges from zero to one at the goal. A higher value for desirability indicates the response value is more desirable. If it is equal to zero, this means a completely undesired response\(^{14}\). Adjusting its weight or importance may alter the characteristics of a goal, and the aim of the optimization is to find a good set of conditions that will meet all the goals. Usually, the weights are used to establish an evaluation of the goal’s importance when maximizing desirability function; in this work, weights are not changed since the four responses have the same importance and are not in conflict within each other.

The ultimate goal of this optimization was to obtain the maximum response that simultaneously satisfied all the variable properties. Table (10) lists the constrains of each variable for computational optimization of the weld bead width, reinforcement height, penetration and heat input. According to this table, five possible runs fulfilled this specified constrains to obtain the optimum values for weld bead width, reinforcement, penetration, heat input and desirability, as given in Table (11). It can be seen that these runs gave a desirability of 0.686 with the optimum values of the weld bead width (9.4793 mm), reinforcement height (3.53625 mm), penetration (3.03997 mm), and heat input (1.27885 KJ/mm). Fig. (13) shows the 3D surface plot for desirability as a function of voltage and wire feeding speed at 8 L/min gas flow rate.

4. CONCLUSIONS

1. RSM achieved by DOE technique has shown its effectiveness and usefulness as a tool to predict the responses in MAG-CO2 welding technique for any given input parameters.
2. Quadratic models were obtained by RSM achieved by DOE technique for the optimum heat input with the optimum dimensions of the weld joint geometry of the welded parts by the CO2-MAG process.
3. The arc voltage and wire feeding speed are found the most effective welding parameters in the predicted quadratic models of weld bead width and reinforcement height, while gas flow rate is only influential in the predicted models of bead penetration and heat input.
4. Wire feeding speed is the most effective welding parameter in predicted quadratic model of the heat input, whereas both voltage and gas flow rate are less influential on this response.
5. Efficient weld joints could be achieved using the welding conditions drawn from the computational optimization. The optimum values of the weld bead width, reinforcement
height, penetration and heat input are (9.4793 mm), (3.53625 mm), (3.03997 mm),
(1.27885 kJ/mm), respectively with a desirability of 0.686.

6. The results indicated that the process input parameters influence the heat input and the
weld bead joint geometry to a significant extent.

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### Table (1): Chemical Composition for Used LCS with Standard Type (wt%).

| Material          | C  | Si  | Mn  | P   | S   | Cr  | Mo  | Ni  | Al  | Co  | Cu  | V  | Fe  |
|-------------------|----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|----|-----|
| Experimental      | 0.13 | 0.015 | 0.450 | 0.003 | 0.003 | 0.001 | 0.002 | 0.043 | 0.036 | 0.007 | 0.001 | Bal. |
| Standard Steel AISI 101 (12) | 0.08 – 0.13 | 0.1 max | 0.3 | 0.04 max | 0.05 max | -- | -- | -- | -- | -- | -- | Bal. |

### Table (2): Mechanical Properties for Used LCS with Standard Type (wt%).

| Material     | Yield strength (MPa) | Tensile strength (MPa) | Elongation (%) |
|--------------|----------------------|------------------------|----------------|
| Experimental | 262                  | 391                    | 42             |

### Table (3): Levels of input parameters used with respective coding.

| +alpha | -alpha | High Level  | Low Level  | Unit     | Input parameter     |
|--------|--------|-------------|------------|----------|---------------------|
| 22     | 18     | 21          | 19         | Volt     | Voltage             |
| 200    | 100    | 175         | 125        | cm/min   | Wire feeding speed  |
| 14     | 5      | 12          | 8          | L/min    | Gas flow rate       |
Table (4): Design Matrix for Input Factors and Experimental Values of Output (Responses).

| Run No. | Bead penetration (mm) | Bead reinforcement (mm) | Bead width (mm) | Gas flow rate (L/min) | Wire feed speed (cm/min) | Voltage (volt) | Type of point | Std |
|---------|-----------------------|-------------------------|-----------------|-----------------------|-------------------------|---------------|---------------|-----|
| 1       | 1.93                  | 3.87                    | 7.18            | 8                     | 125                     | 19            | Factorial     | 2   |
| 1.4     | 3                     | 9.52                    | 8               | 125                   | 21                      |               | Factorial     | 2   |
| 3.04    | 3.68                  | 9.17                    | 8               | 175                   | 19                      | Factorial     | 3   |
| 3.34    | 3.04                  | 10.82                   | 8               | 175                   | 21                      | Factorial     | 4   |
| 2.76    | 3.98                  | 7.13                    | 12              | 125                   | 19                      | Factorial     | 5   |
| 2       | 2.82                  | 8.75                    | 12              | 125                   | 21                      | Factorial     | 6   |
| 1.61    | 3.5                   | 8.98                    | 12              | 175                   | 19                      | Factorial     | 7   |
| 1.99    | 3.25                  | 12.58                   | 12              | 175                   | 21                      | Factorial     | 8   |
| 2.43    | 4.5                   | 5.05                    | 10              | 150                   | 18                      | Axial         | 9   |
| 2       | 3.2                   | 9.75                    | 10              | 150                   | 22                      | Axial         | 10  |
| 1.68    | 3.83                  | 6.5                     | 10              | 100                   | 20                      | Axial         | 11  |
| 2.75    | 3.5                   | 11.03                   | 10              | 200                   | 20                      | Axial         | 12  |
| 2.62    | 3.03                  | 11.78                   | 6               | 150                   | 20                      | Axial         | 13  |
| 1.88    | 2.97                  | 11.03                   | 14              | 150                   | 20                      | Axial         | 14  |
| 2.42    | 3.17                  | 12                      | 10              | 150                   | 20                      | Center        | 3   |
| 2.32    | 3.04                  | 11.5                    | 10              | 150                   | 20                      | Center        | 4   |
| 2       | 3.02                  | 11.24                   | 10              | 150                   | 20                      | Center        | 5   |
| 2.12    | 2.85                  | 11.51                   | 10              | 150                   | 20                      | Center        | 6   |
| 2.34    | 3                     | 10.71                   | 10              | 150                   | 20                      | Center        | 7   |

Table (5): The Results of Calculated Welding Speed and Heat Input.

| Run No. | Calculated Heat input (KJ/mm) | Calculated Welding Speed (mm/min) | Welding Current (Amp.) | Welding Voltage (volt) | Type of point | Std |
|---------|-------------------------------|----------------------------------|------------------------|-----------------------|---------------|-----|
| 0.85    | 64.6                          | 60                               | 19                     | Factorial             | 12            | 1   |
| 0.7     | 73.1                          | 51                               | 21                     | Factorial             | 7             | 2   |
| 1.31    | 90                            | 129                              | 19                     | Factorial             | 8             | 3   |
| 1      | 105                           | 104                              | 21                     | Factorial             | 4             |     |
| 0.74    | 69.7                          | 57                               | 19                     | Factorial             | 14            | 5   |
| 0.55    | 85.7                          | 47                               | 21                     | Factorial             | 4             | 6   |
| 1.1     | 103.4                         | 125                              | 19                     | Factorial             | 16            | 7   |
| 0.96    | 115.4                         | 110                              | 21                     | Factorial             | 18            | 8   |
| 1.4     | 66.7                          | 108                              | 18                     | Axial                 | 9             | 9   |
| 1.08    | 85                            | 87                               | 22                     | Axial                 | 15            | 10  |
| 0.28    | 65                            | 19                               | 20                     | Axial                 | 6             | 11  |
| 1      | 125                           | 130                              | 20                     | Axial                 | 2             | 12  |
| 0.79    | 95.32                         | 78                               | 20                     | Axial                 | 19            | 13  |
| 0.45    | 115                           | 54                               | 20                     | Axial                 | 10            | 14  |
| 1.2     | 70                            | 87                               | 20                     | Center                | 3             | 15  |
| 1.25    | 76.92                         | 100                              | 20                     | Center                | 11            | 16  |
| 1.31    | 74.5                          | 102                              | 20                     | Center                | 17            | 17  |
| 1.3     | 71                            | 96                               | 20                     | Center                | 5             | 18  |
| 1.15    | 76.5                          | 92                               | 20                     | Center                | 13            | 19  |
| 1.19    | 72.8                          | 90                               | 20                     | Center                | 20            | 20  |
**Table (6):** Analysis of Variance (ANOVA) for Response Surface Reduced Quadratic Model (Bead width).

| Source                  | Sum of squares | df  | Mean square | F value | Prob > F | Source   |
|-------------------------|----------------|-----|-------------|---------|----------|----------|
| < 0.0001 significant    | 64.21          | 4   | 18.88       | 73.62   | < 0.0001 | Model    |
| < 0.0001                | 69.10          | 1   | 20.32       | 20.32   | < 0.0001 | A-Voltage |
| < 0.0001                | 91.75          | 1   | 26.98       | 26.98   | < 0.0001 | B-Wire feeding speed |
| < 0.0001                | 40.30          | 1   | 11.85       | 11.85   | < 0.0001 | A²       |
| 0.29                    | 0.29           | 15  | 4.41        | 4.41    | 0.05     | Residual |
| 0.3758 not significant  | 1.39           | 10  | 0.32        | 3.24    | 0.023    | Lack of Fit |
|                         |                | 19  | 79.94       |         |          | Core Total |

**Table (7):** Analysis of Variance (ANOVA) for Response Surface Reduced Quadratic Model (Bead Reinforcement).

| Source                  | Sum of squares | df  | Mean square | F value | Prob > F | Source   |
|-------------------------|----------------|-----|-------------|---------|----------|----------|
| < 0.0001 significant    | 77.27          | 5   | 0.74        | 197.68  | < 0.0001 | Model    |
| < 0.0549                | 4.80           | 1   | 0.046       | 0.046   | < 0.0549 | B-Wire feeding speed |
| 0.0011                  | 16.86          | 1   | 0.16        | 0.16    | < 0.0011 | AB       |
| < 0.0001                | 121.35         | 1   | 1.17        | 1.17    | < 0.0001 | A²       |
| < 0.0001                | 73.91          | 1   | 0.71        | 0.71    | < 0.0001 | B²       |
|                         | 9.634E-003     | 14  | 0.13        | 0.13    | 0.88     | Residual |
| 0.5944 not significant  | 0.88           | 9   | 9.171E-003  | 0.083   | 0.010    | Lack of Fit |
|                         |                | 19  | 3.86        |         |          | Core Total |

**Table (8):** Analysis of Variance (ANOVA) for Response Surface Reduced Quadratic Model (Bead Penetration).

| Source                  | Sum of squares | df  | Mean square | F value | Prob > F | Source   |
|-------------------------|----------------|-----|-------------|---------|----------|----------|
| < 0.0001 significant    | 132.20         | 5   | 0.87        | 132.20  | < 0.0001 | Model    |
| 0.0005                  | 20.52          | 1   | 0.14        | 20.52   | < 0.0001 | A-Voltage |
| < 0.0001                | 154.19         | 1   | 1.02        | 154.19  | < 0.0001 | B-Wire feeding speed |
| < 0.0001                | 76.04          | 1   | 0.50        | 76.04   | < 0.0001 | C-Gas flow rate |
| < 0.0001                | 73.69          | 1   | 0.49        | 73.69   | < 0.0001 | AB       |
| < 0.0001                | 336.55         | 1   | 2.22        | 336.55  | < 0.0001 | BC       |
|                         | 6.583E-003     | 14  | 0.092       | 0.092   | 0.9237   | Residual |
| 0.9237 not significant  | 0.34           | 9   | 3.892E-003  | 0.035   | 0.011    | Lack of Fit |
|                         |                | 19  | 4.44        |         |          | Core Total |

**Diyala Journal of Engineering Sciences, Vol. 08, No. 02, June 2015**

58
Table (9): Analysis of Variance (ANOVA) for Response Surface Reduced Quadratic Model (Heat Input).

| p-value | F value | Mean square | Df | Sum of squares | Source     |
|---------|---------|-------------|----|----------------|------------|
| < 0.0001 significant | 134.09 | 0.37 | 5 | 1.83 | Model |
| < 0.0001 | 47.60 | 0.13 | 1 | 0.13 | A-Voltage |
| < 0.0001 | 202.59 | 0.55 | 1 | 0.55 | B-Wire feeding speed |
| < 0.0001 | 32.75 | 0.090 | 1 | 0.090 | C-Gas flow rate |
| < 0.0001 | 220.52 | 0.60 | 1 | 0.60 | B² |
| < 0.0001 | 235.34 | 0.64 | 1 | 0.64 | C² |
| 2.734E-003 | 14 | 0.038 | Residual |
| 0.8401 not significant | 0.48 | 1.972E-003 | 9 | 0.018 | Lack of Fit |
| 4.107E-003 | 5 | 0.021 | Pur Error |
| 19 | 1.87 | Core Total |

Table (10): Constrains Used for the Computational Optimization.

| Importance | Upper Weight | Lower Weight | Upper Limit | Lower Limit | Goal        | Name                |
|------------|--------------|--------------|-------------|-------------|-------------|---------------------|
| 3          | 1            | 1            | 21          | 19          | is in range  | A-Voltage           |
| 3          | 1            | 1            | 175         | 125         | is in range  | B-Wire feeding speed |
| 3          | 1            | 1            | 12          | 8           | is in range  | C-Gas flow rate     |
| 3          | 1            | 1            | 12.58       | 5.05        | maximize     | Bead width          |
| 3          | 1            | 1            | 4.5         | 2.82        | maximize     | Bead reinforcement   |
| 3          | 1            | 1            | 3.34        | 1.4         | maximize     | Penetration          |
| 3          | 1            | 1            | 1.408       | 0.28        | maximize     | Heat input           |

Table (11): The Optimum Solutions of the Desirability.

| Desirability | Heat input (KJ/mm) | Penetration (mm) | Bead reinforcement (mm) | Bead Width (mm) | Gas flow rate (L/min) | Wire feeding speed (mm/min) | Voltage (Volt) | No. |
|--------------|---------------------|------------------|-------------------------|-----------------|-----------------------|-----------------------------|----------------|-----|
| 0.686 selected | 1.2778 | 3.03997 | 3.53625 | 9.4793 | 8 | 175 | 19 | 1 |
| 0.686 | 1.2827 | 3.02974 | 3.53624 | 9.47931 | 8 | 175 | 19 | 2 |
| 0.686 | 1.28579 | 3.02143 | 3.53625 | 9.47929 | 8 | 175 | 19 | 3 |
| 0.686 | 1.27745 | 3.03992 | 3.52646 | 9.52929 | 8 | 175 | 19 | 4 |
| 0.686 | 1.27662 | 3.03999 | 3.53439 | 9.48221 | 8 | 175 | 19 | 5 |
AND JOINT GEOMETRY

INPUT THE HEAT MAG WELDING PROCESS PARAMETERS ON 2

STUDY THE EFFECT OF CO\textsubscript{2} MAG WELDING PROCESS PARAMETERS ON THE HEAT INPUT AND JOINT GEOMETRY DIMENSIONS USING EXPERIMENTAL AND COMPUTATIONAL METHODS

**Fig. (1):** CO\textsubscript{2}-MAG Welding Machine and Specimens Before and After Welding.

**Fig. (2):** A schematic Illustration Profile of the Joint Geometry \(^{(13)}\).

**Fig. (3):** Normal Probability Plot of Residuals for Bead Width Data.
Fig. (4): Residual versus Predicted Responses for Bead Width Data.
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DIMENSIONS USING EXPERIMENTAL AND COMPUTATIONAL METHODS

(C)

Fig. (5): Predicted versus actual for (A) bead width data, (B) reinforcement and (C) Penetration.
Fig. (6): Perturbation of (A) Bead Width, (B) Reinforcement and (C) Penetration on Wire Feeding Speed and Gas Flow Rate.
Fig. (7): Contour Graph of Bead Width as a function of Voltage and Wire Feeding Speed at 10 L/min Gas Flow Rate.

Fig. (8): Contour Graph of Bead Reinforcement as a function of Voltage and Wire Feeding Speed at 10 L/min Gas Flow Rate.
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Design-Expert® Software
Factor Coding: Actual
Penetration
- Design points above predicted value
- Design points below predicted value

X₁ = A: Voltage
X₂ = B: Wire feeding speed

Actual Factor
C: Gas flow rate = 8

Penetration

A: Voltage
B: Wire feeding speed

(A)

Penetration

A: Voltage
B: Wire feeding speed

(B)
Fig. (9): 3D Graph of Bead Penetration as a function of Voltage and Wire Feeding Speed at (A, B, C) Gas Flow Rate 8, 10 and 12 L/min, respectively and (D) Cube Shape for Penetration.
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Fig. (10): Predicted Versus Actual Heat Input Data.

Fig. (11): Perturbation of Heat Input on Wire Feeding Speed and Gas Flow Rate.
STUDY THE EFFECT OF CO₂ MAG WELDING PROCESS PARAMETERS ON THE HEAT INPUT AND JOINT GEOMETRY DIMENSIONS USING EXPERIMENTAL AND COMPUTATIONAL METHODS

(A) Design-Expert® Software
Factor Coding: Actual
Heat input
- Design points above predicted value
- Design points below predicted value

X1 = A: Voltage
X2 = B: Wire feeding speed
Actual Factor
C: Gas flow rate = 10

(B) Design-Expert® Software
Factor Coding: Actual
Heat input
- Design points above predicted value
- Design points below predicted value

X1 = A: Voltage
X2 = B: Wire feeding speed
Actual Factor
C: Gas flow rate = 10
Fig. (12): 3D Graph of Heat Input as a function of Voltage and Wire Feeding Speed (A, B, C) at Gas Flow Rates 8, 10 and 12 L/min, respectively and (D) Cube Shape for Heat Input
Fig. (13): 3D Surface Plot for Desirability.
study the effect of CO₂ mag welding process parameters on the heat input and joint geometry dimensions using experimental and computational methods

الخلاصة

في هذا البحث تم التنبؤ بموديل بالحرارة الداخلة وأبعاد الشكل الهندسي للوصلة الملحومة بطريقة لحام القوس المعدني بغاز ثاني أوكسيد الكربون عن طريق عمل نماذج رياضية لهذا الغرض، قبل عملية اللحام تم تهيئة عينات الاختبار العملية للصلب وحامّها تناكياً بعد ذلك باستخدام سلك لحام منصهر في بركة اللحام بأدخال الحرارة الداخلة بشكل مستمر. تم قياس أبعاد درزة اللحام ومن ثم تحليل نتائجها لتحقيق من صحة النماذج باستخدام تقنية تصميم التجارب وطريقة الاستجابة السطحية. هذه النماذج وجدت لتكون قادرة على التنبؤ بأمثلية الأبعاد المطلوبة للشكل الهندسي بدالة عرض درزة اللحام، ارتفاع المنطقة المحواة باللحام وعمق اللحام. بينت النتائج المستحصلة بأن الحرارة الداخلة تعتمد على الفولتية، سرعة تغذية السلك، معدل جريان الغاز، بينما فيما يخص أبعاد درزة اللحام فإن تأثير معدل جريان الغاز عليها كان قليل. تمتد المقارنة بين النتائج العملية والنتائج الحاسوبية ووجد أن هناك تطابق جيد بينهما.

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