

precipitation layer formation on the workpart surface is the stirring or agitation of electrolytes [15, 17-18].

For most electropolishing processes, there exists a particular potential-current relationship that determines the optimum electropolishing parameters. This relationship is largely determined by the type of material and electrolyte used in the process. In a typical relationship, the current would increase approximately linearly at low potential levels until it reaches a threshold, after that there exists a plateau stage in which the current keeps more or less constant as the potential increases. At this stage, the electropolishing is dominated by mass transportation phenomenon. The ions diffuse through the surface layer at a stable rate, creating electropolishing current that is little dependent on the voltage level. This is widely regarded as the suitable envelop for electropolishing [19, 20]. When the potential is sufficiently high, the current will start to increase again in a more drastic rate, which is referred to as chemical pitting [17, 18]. At this stage significant breakdown of either the electrolyte or oxide layer occurs, and the resulting part surface is often affected by pitting effect. In short, the first step of the electropolishing experiment would be to establish the potential-current relationship for the chosen electrolyte and identify the plateau stage.

It was also reported that other factors such as temperature [14, 21] and water content in the electrolyte [17] could have significant effect on the electropolishing effects. Higher temperature could promote the mass transportation and therefore facilitate the polishing reaction, however it could also cause unwanted decomposition reactions, therefore has a mixed effect on electropolishing. On the other hand, water is considered to be detrimental to electropolishing since it could result in excessive oxidation of the surface and the formation of hydrogen gas, which are both unwanted for the process.

Recently, more sophisticated electropolishing by pulse AC current has been reported [22, 23]. It was suggested that via the switching of electrode polarity, the process could replenish the ions in the electrolyte more efficiently and help the process to maintain high limit current. Due to the lack of high accuracy AC waveform rectifier, this alternative was not investigated in the current study.

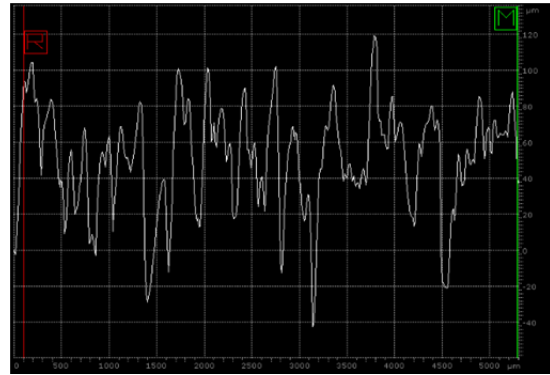
Experiments and Discussions

In this study, effort was focused on the investigation of electropolishing with titanium Ti6Al4V parts made by electron beam melting (EBM) process. Titanium alloys have been notoriously difficult to process with chemical and electrochemical methods. Due to the existence of the highly stable oxide thin film on the surface, traditionally only a few acids could effectively react with titanium alloys, including hydrofluoric acid and perchloric acid [24, 25]. These chemicals are highly hazardous and could cause serious accidents if not used with extreme care. Recently, a non-toxic and non-explosive recipe has been patented for the effective electropolishing of titanium alloys [21]. This electrolyte includes ethanol, isopropyl alcohol, aluminum chloride and zinc chloride. This non aqueous electrolyte solution was successfully used to polishing both CP-Ti and Ti6Al4V alloy and achieved surface finish of $R_a < 100\mu\text{m}$. This electrolyte solution could be easily realized in regular lab environment with minimum safety concerns, and was adopted for further investigation in this study.

Ti6Al4V is the most widely used material for EBM process, which sees many potential applications in aerospace and biomedical industries. The surface finish of typical EBM parts ranges between 20-30 μm . The surface finish of the top surface is usually slightly better, while the sides are usually rougher. Due to the use of relatively coarse powder compared to the laser based PBF-AM process and the larger size of the electron beam, the surface quality issue is more significant with the EBM process. In the current study, sample plates with flat surface area of 5mmx20mm was designed and fabricated by the EBM S400 system using the default Ti6Al4V melt theme. The sample was oriented in the build so that the large flat surfaces are oriented vertically. Fig.3 shows one of the sample part as well as the surface profile measured by a Zygo surface profilometer. The surface finish of the large flat surface was about $R_a=23\mu\text{m}$, which agreed with the literature.



(a) Sample part



(b) Surface profile

Fig.3 EBM sample for electropolishing experiment

The test setup was designed carefully to achieve accurate control of the electrode distance, dipping depth and agitation of the electrolyte. As shown in Fig.4, a glass beaker was used as container of electrolyte, and the electrodes were fixed in a holding plate, which was in turn fixed by a central threaded rod and three guide bars. Through the adjustment at the central threaded rod, the holding plate could move up or down by sliding along the guide bar, therefore achieving accurate control of the dipping depth of the electrodes. The guide bar also served as electrical path for easy clamp of crocodile clips. A magnetic stirring bar was placed at the bottom of the beaker to provide agitation during the electropolishing. For each experiment, roughly 300mL of electrolyte was used. The electrolyte was made by following the recipe provided in previous literatures: 1L of electrolyte should consist of: 700mL of ethanol, 300mL of isopropyl alcohol, 60g AlCl_3 and 250g ZnCl_2 . A DC power supply with maximum potential of 75V was used for all experiments. During the experiment, the beaker was placed in ice water bath in order to maintain low temperature.

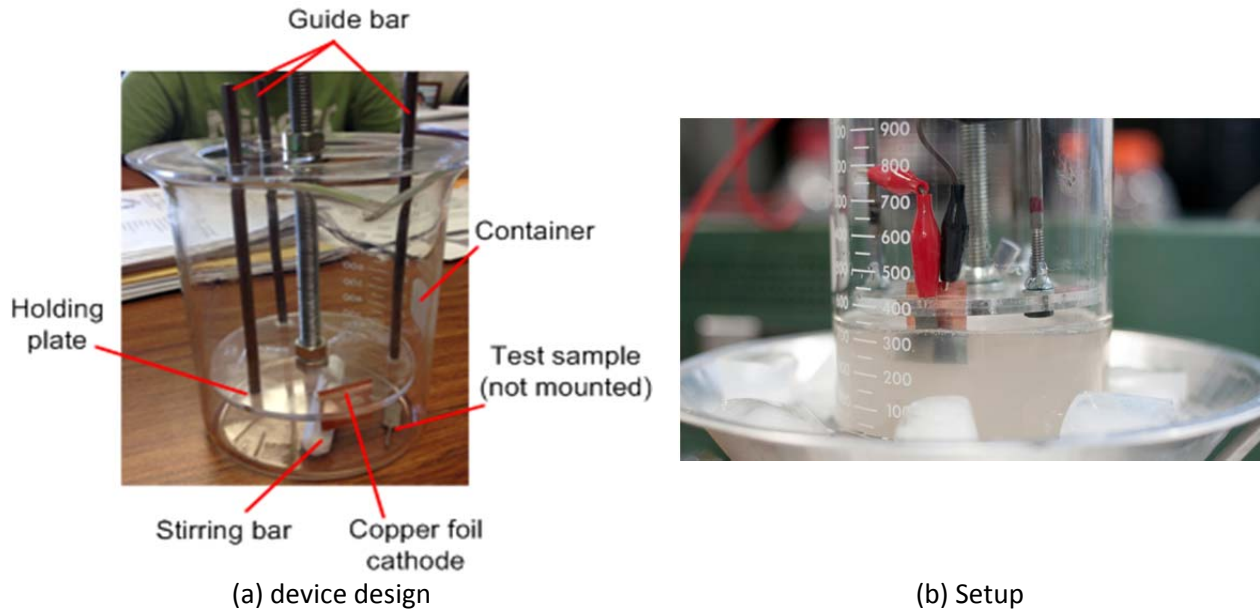


Fig.4 Electropolishing experimental setup

Three electrode distances were investigated for the study, which were 5mm, 7.5mm and 10mm. The potential-current curve was obtained by gradually increase the potential values at each electrode distance setup and record the change of currents. A constant stirring setting was used throughout all the tests, although the control was not accurate and therefore no accurate rpm was recorded. Fig.5 shows the relationship for all three setups. None of the curve exhibited significant plateau, however, there existed a rather drastic slope at around 65-70VDC for all three setups, and the increase of current before this threshold was rather mild. It was also observed that accompanied the sharp rise of current was the formation of gas phase. Therefore, it was speculated that 70VDC was the threshold of significant chemical pitting, and while no apparent plateau was present, the electropolishing would likely to be both stable and rapid at around 50-60VDV range. With that in mind, an electropolishing potential of 55VDC was selected for the subsequent experiments.

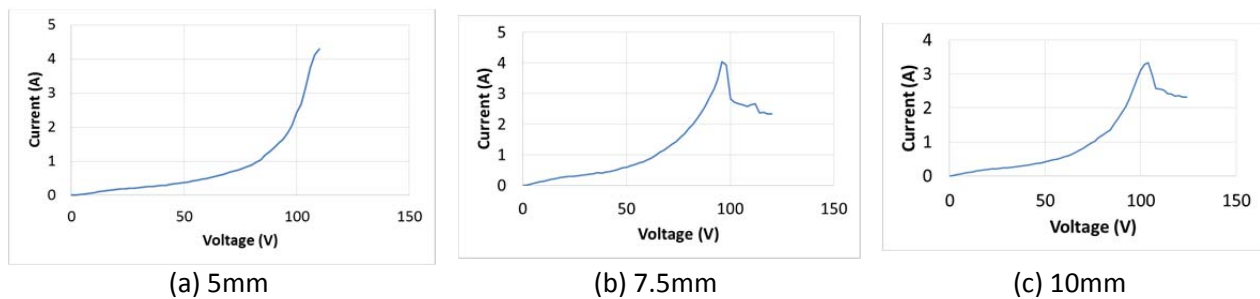


Fig.5 Potential-current curve at different electrode distances

Using the three electrode distance setups, electropolishing experiments were carried out with different total polishing time. It was found in the preliminary trial that considerable reaction production accumulation as well as heating occurred during the experiments. Therefore, in order to alleviate this

issue, an artificial electropolishing waveform was introduced. The electropolishing would be carried out for 60 seconds, followed by a 10 seconds break with no potential, so the agitation could have more sufficient time to re-balance the electrolyte and wash away the surface contaminants. It was also worth noting that excessive agitation also seemed to affect the process by creating significant turbulence and vortex in the flow. An stirring setting of about 400rpm was set, although it was not strictly kept constant during some of the experiments in order to more effectively remove the surface contaminations.

The relationship between the final surface finish and the electropolishing setup is shown in Fig.6. No apparent improvement could be observed for short electropolishing time. However, significant difference occurred when polishing time was 20 minutes. As expected, the setup with 5mm electrode distance resulted in the most significant improvement of surface quality likely due to the larger current and faster reaction rate. On the other hand, the polishing rate of setup with 10mm electrode distance did not appear to have significant effect on the surface even after elongated polishing time. It is worth noting that significant non-uniformity was also observed for most of the samples. Within the same sample, there exist areas that had better surface finish than the others, which could be readily explained by the observed turbulence of the electrolyte flow. From Fig.4 it is easy to realize that the setup does not create a linear laminar flow but rather vortex flow, therefore different areas of the flat part is subject to different shear and normal pressures from the electrolyte flow. Fig.7 shows some of the final parts, and it could be easily seen that the edges of the parts are polished more significantly, which are the areas that undergoes more pronounced flow agitations. The best surface finish achieved by the 5mm+20minute sample was about $R_a=6\mu\text{m}$, which was a significant improvement compared to the original sample.

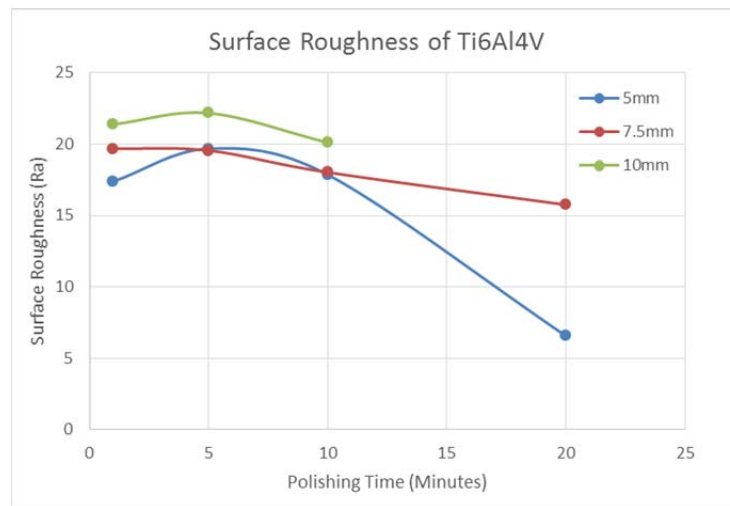


Fig.6 Effect of electropolishing parameter on the surface quality



(a) 5mm+10 minutes



(b) 7.5mm+10 minutes



(c) 5mm+ 20 minutes

Fig.7 Samples after electropolishing

The experiment also revealed some issues. From Fig.7(c), it could be clearly seen that a rather serious shape accuracy loss occurred on the processed parts. This could be contributed by both the non-uniform electrolyte agitation and the insufficient control of the total amount of electropolishing. Another issue was the repeatability of the experiments. Without accurate control of stirring speed and temperature, the electropolishing could still exhibit significant difference even if the other parameters are well controlled. Fig.8 shows a sample that after electropolishing at 5mm+20 minutes setup, and the surface finish at some area was $R_a < 100\text{nm}$. Further study is under way to redesign the experimental setup and to achieve better control of the process in order to duplicate the good results and identify critical parameters.



Fig.8 Electropolished sample with extraordinary surface finish

Conclusion

The preliminary study has shown that electropolishing possess potential to be used as an effective surface treatment method for PBF-AM fabricated parts. Ti6Al4V was chosen as the material in this study because of its popularity with PBF-AM processes as well as its difficult with traditional processes, and the results showed significant promise. Further studies are ongoing that need to achieve better control of the electropolishing process and better understanding of the key parameters.

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