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CORRECTION

Correction: Machinability investigations through novel controlled flushing characteristics in wire electric discharge machining of M42 high-speed steel

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The publication of this article unfortunately contained typos.

The last column of Table 3: Kerf width was clipped during revisions. The column is corrected and is given below.

The Eq. 2 carried a mistake which is correct as below.

$$\mathrm{MRR} = 100 \times (0.11851 + 0.001551\ \mathrm{Vs} + 0.001869\ \mathrm{Pf} - 0.005825\ \mathrm{Dn} + 0.0009461\ \mathrm{d}) \quad (2)$$

The Fig. 13(a) carried a typo in units of MRR as revised below.

The Table 8 carried a typo in MRR units (previously g/mm^3; correct mm^3/min) and decimal points. The corrected table is provided below.

The original article can be found online at https://doi.org/10.1007/s00170-022-08786-0.

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Table 3 Design of experiments along with output results

Control variables					Output responses		
Exp	Servo voltage	Flushing pressure	Nozzle diameter	Nozzle-work-piece gap	Material removal rate	Surface roughness	Kerf width
	Vs	Pf	Dn	S	MRR	Ra	KW
Unit	Volt	Kg/cm^2	mm	mm	mm^3/min	μm	mm
1	40	4	4	3	16.51	2.01	0.354
2	40	4	6	10	16.19	2.02	0.3565
3	40	4	8	24	16.26	2.06	0.3608
4	40	8	4	3	17.54	1.93	0.3547
5	40	8	6	10	17.26	1.96	0.3556
6	40	8	8	24	17.29	2.00	0.3626
7	40	12	4	10	18.74	1.90	0.3586
8	40	12	6	24	18.95	1.93	0.363
9	40	12	8	3	16.26	2.00	0.3571
10	50	4	4	24	20.66	1.99	0.3609
11	50	4	6	3	17.41	2.09	0.3549
12	50	4	8	10	16.32	2.12	0.3591
13	50	8	4	10	19.36	1.96	0.359
14	50	8	6	24	19.83	2.00	0.3656
15	50	8	8	3	17.01	2.08	0.3597
16	50	12	4	24	21.99	1.93	0.3662
17	50	12	6	3	18.70	2.00	0.361
18	50	12	8	10	17.68	2.02	0.3636

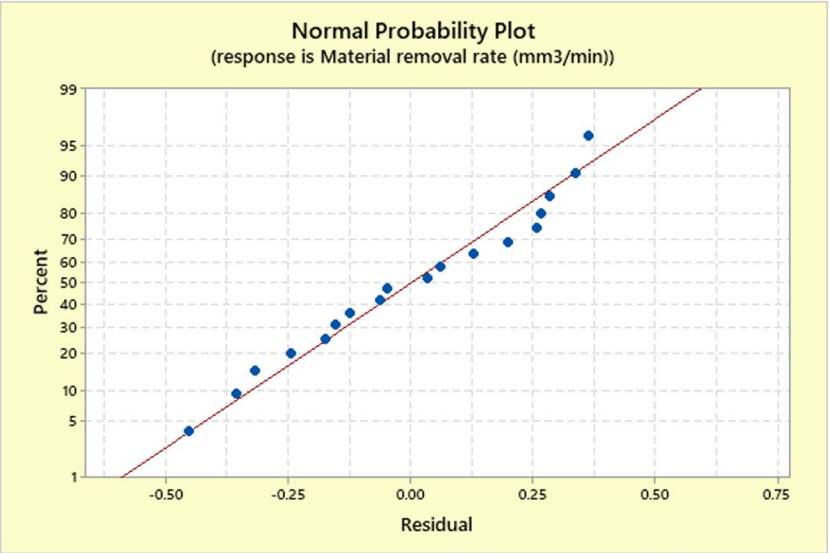

Fig. 13 Graphical illustration to show the Pareto and normal plots for (a) MRR

Table 8 Detailed data for confirmatory experimentation

Response measures	DOE data		SN ratio data			% Improvement from DOE results
	Un-optimized settings	Response values	Optimized settings	Predicted results based on DOE	Confirmatory experiments results	
MRR (mm^3/min)	Vs2,Pf3, Dn1, d3	21.99	Vs2,Pf3, Dn1, d3	21.79	24.4	9.870
Ra (μm)	Vs1,Pf3, Dn1, d2	1.9	Vs1,Pf3, Dn1,d3	1.8805	1.773	7.163
Kw (mm)	Vs1,Pf1, Dn1, d1	0.354	Vs1,Pf1, Dn1, d1	0.3527	0.339	4.425