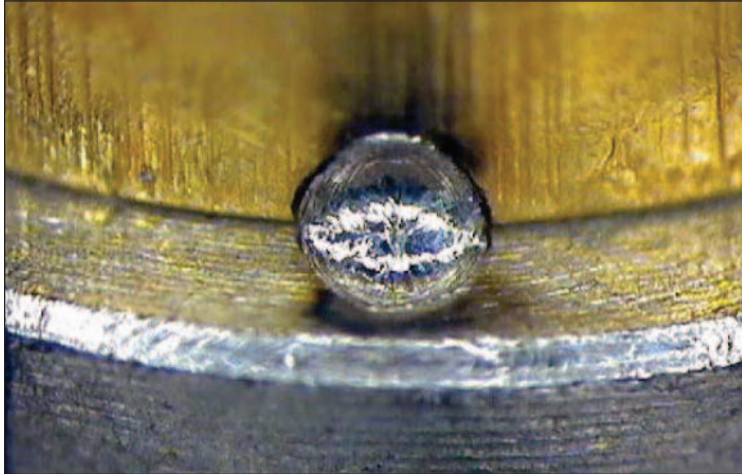
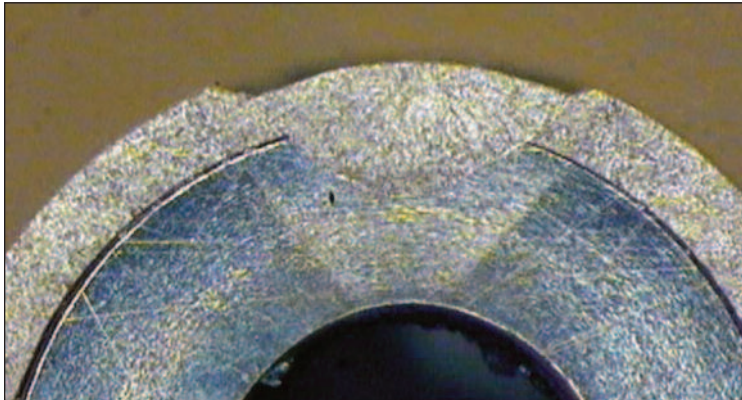


Welding Applications

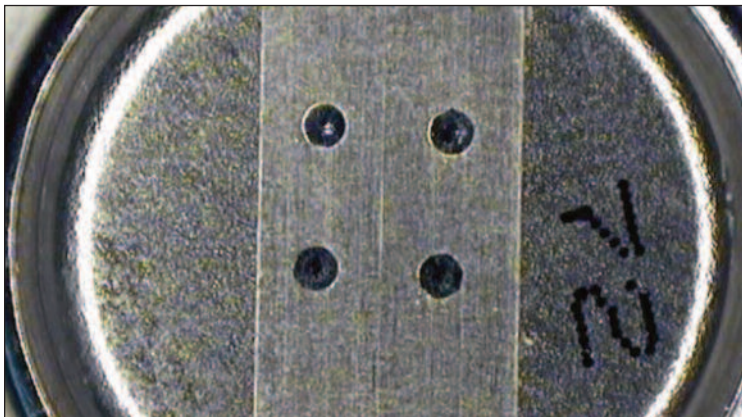
LW5A, 15A and 25A welders



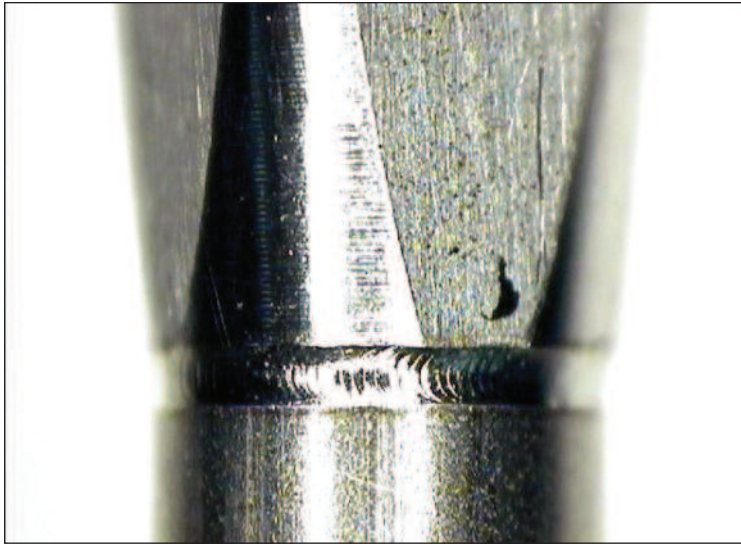
Application	TO header weld
Laser	LW5A
Materials	304L SS & gold plated CRS
Weld type	Fillet
Focus head	CCTV 100mm
Fiber	300 SI
Penetration	0.015"
Spot size	0.015"
Pulse width	2 ms
Energy	1 J
Gas shroud	Argon



Application	Tube/spring attach
Laser	LW15A
Materials	17-4 & 304 SS
Weld type	Lap
Focus head	CCTV 70mm
Fiber	600 SI
Penetration	0.015"
Spot size	0.02"
Pulse width	2.3 ms
Energy	6 J
Gas shroud	Argon



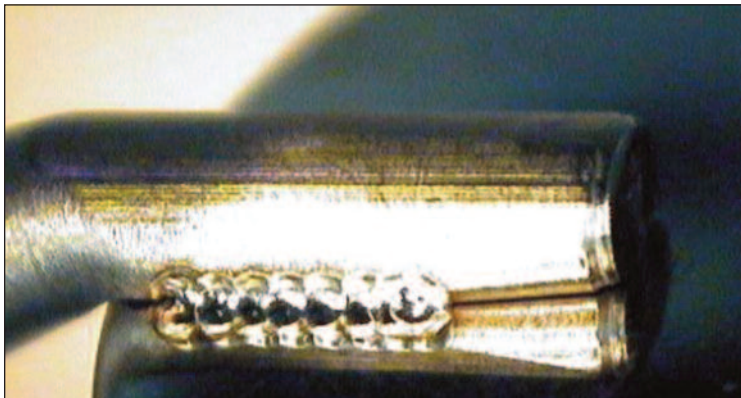
Application	Battery tab weld
Laser	LW5A
Materials	304L ss & nickel
Weld type	Lap
Focus head	CCTV 70mm
Fiber	400 SI
Penetration	0.007"
Spot size	0.018"
Pulse width	6.0 ms
Energy	4 J /spot
Gas shroud	Argon



Application	Tube attach
Laser	LW15A
Materials	304 SS
Weld type	Seam
Focus head	CCTV 70mm
Fiber	400 SI
Penetration	0.015"
Spot size	0.018"
Pulse width	2.4 ms
Energy	1.6 J
Rep. rate	7 Hz
Gas shroud	Argon



Application	Tab attach
Laser	LW25A
Materials	4047 & 6061 aluminum
Weld type	Lap
Focus head	CCTV 100/70mm
Fiber	400 SI
Penetration	0.015"
Spot size	0.015"
Pulse width	4.0 ms
Energy	24 J
Gas shroud	Argon



Application	Dental mirror arm attach
Laser	LW5A
Materials	304 SS
Weld type	Fillet
Focus head	CCTV 70mm
Fiber	400 SI
Penetration	0.01"
Spot size	0.02"
Pulse width	3.8 ms
Energy	4 J
Gas shroud	Argon



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