

LASER WELDING PARAMETERS

	POWER	SPOT	TIME m/s	FREQUENCY	WAVE
Yellow Gold thin	2.0	0.2	2.0	5.0	SLO+
Yellow Gold wire	2.4	0.4	2.4	6.5	SLO+
Yellow Gold smoothing	3.6	0.7	3.6	6.5	SLO+
White Gold thin	1.5	0.2	1.6	6.5	SLO-
White Gold wire	1.7	0.4	1.7	6.5	SLO-
White Gold smoothing	2.3	0.8	2.1	6.5	SLO-
Rose Gold thin	1.6	0.2	1.9	5	SLO+
Rose Gold wire	1.8	0.3	2.2	5	SLO+
Rose Gold smoothing	3.2	0.6	3.1	6.5	SLO+
Silver thin	3.7	0.3	3.7	5	NORM
Silver wire	4.2	0.3	4.2	5	NORM
Silver smoothing	4.5	0.4	4.5	4	NORM
Platinum thin	1.8	0.4	0.8	5	NORM
Platinum wire	1.8	0.5	1	1.6	NORM

Platinum smoothing	2.2	0.8	1.8	1.9	NORM
Stainless steel thin	1	0.3	1	6	NORM
Stainless wire	1.2	0.5	1.2	7	NORM
Stainless steel smoothing	1.8	0.7	1.8	7	NORM
Titanium thin	1.8	0.7	1.8	7	NORM
Titanium wire	1	0.2	0.2	2.5	NORM
Titanium smoothing	1.0	0.2	0.2	2.5	NORM
Palladium thin	1.6	0.2	1.3	5.0	NORM
Palladium wire	1.8	0.5	1.6	6.5	NORM
Palladium smoothing	2.4	0.7	1.8	8	NORM
Nickel Silver thin	1.6	0.7	1.4	5	NORM
Nickel Silver wire	1.4	0.	1.4	7.0	NORM
Nickel Silver smoothing	1.	0.9	1.9	8	NORM