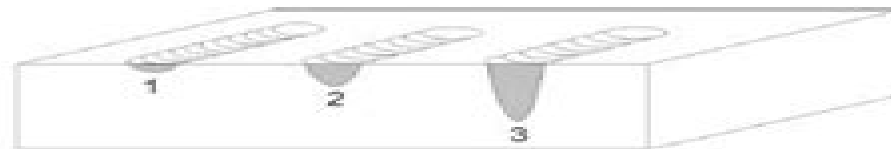


1. Conduction
2. Conduction / penetration
3. Penetration or keyhole



**Figure F.** Three types of welds created according to the power density and pulse duration of the laser pulse.

- Conduction mode welding is performed at low energy density forming a weld nugget that is shallow and wide.
- Conduction/penetration mode occurs at medium energy density, and shows more penetration than conduction mode.
- The penetration or keyhole mode welding is characterized by deep narrow welds. In this mode the laser light forms a filament of vaporized material known as a “keyhole” that extends into the material and provides conduit for the laser light to be efficiently delivered into the material. This direct delivery of energy into the material does not rely on conduction to achieve penetration, and so minimizes the heat into the material and reduces the heat affected zone.

## 2.3 Key Welding Parameters

The key welding parameters can be divided into two parts, those that concern the parts themselves and the laser parameters.

### 2.3.1 Joint Design and Fit-up

As laser welding is a non-contact process there are a broad number of joint geometries that can be welded. In addition the laser is able to weld into areas with limited access. The main joint designs are shown in Figure N. Ideally in any weld joint the thinner material is the top sheet.



**Figure G.** Most common weld joints, most other types are variations on these.

# Laser Welding Practical Guide

**M Carnoy**



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