



## Laser Welder Starting Parameter

Materials	Welding Methods	Material Thickness	Power Percentage	Wobble Length	Wobble Frequency	Gas Pre-flow	Gas Post-flow
Carbon Steel (Q235B)	Stitch Welding	1mm	40	2/3	60/80	15	20
		2mm	70	2/3	60/80	15	20
		3mm	85	2/3	60/80	15	20
		4mm	100	2/3	60/80	15	20
Stainless Steel (SUS3004)	Stitch Welding	1mm	35	2/3	60/80	15	20
		2mm	70	2/3	60/80	15	20
		3mm	90	2/3	60/80	15	20
		4mm	100	2/3	60/80	15	20
Brass	Stitch Welding	1mm	40	2/3	60/80	15	20
		2mm	70	2/3	60/80	15	20
		3mm	100	2/3	60/80	15	20
Galvanized Sheet	Stitch Welding	1mm	40	2/3	60/80	15	20
		2mm	80	2/3	60/80	15	20
		3mm	100	2/3	60/80	15	20
Aluminum Alloy	Stitch Welding	1mm	55	2/3	60/80	15	20
		2mm	90	2/3	60/80	15	20
		3mm	100	2/3	60/80	15	20