

一. stainless steel									
Material and thickness (mm)	laser power (W)	Laser Frequency (HZ)	Duty cycle (%)	Swing frequency (HZ)	Swing length (mm)	wire feeding speed (mm/s)	Welding wire model	welding angle	form
stainless steel1.0	500	3000	100	35	2	12	ER304.0.8	plane	penetration
stainless steel1.0	450	3000	100	35	2	12	ER304.0.8	interior angle	white
stainless steel1.0	500	3000	100	35	2	12	ER304.0.8	External angle	75%penetration
stainless steel1.5	550	3000	100	35	2	12	ER304.0.8	plane	penetration
stainless steel1.5	500	3000	100	35	2	12	ER304.0.8	interior angle	white
stainless steel1.5	550	3000	100	35	2	12	ER304.0.8	External angle	80%penetration
stainless steel2.0	1000	3000	100	35	2.5	12	ER304.1.0	plane	penetration
stainless steel2.0	800	3000	100	35	2.5	12	ER304.1.0	interior angle	white
stainless steel2.0	1000	3000	100	35	2.5	12	ER304.1.0	External angle	70%penetration
stainless steel2.5	1200	3000	100	35	2.5	12	ER304.1.0	plane	penetration
stainless steel2.5	1000	3000	100	35	2.5	12	ER304.1.0	interior angle	white
stainless steel2.5	1200	3000	100	35	2.5	12	ER304.1.0	External angle	80%penetration
stainless steel3.0	1600	3000	100	35	3	12	ER304.1.2	plane	penetration
stainless steel3.0	1350	3000	100	35	3	12	ER304.1.2	interior angle	white
stainless steel3.0	1400	3000	100	35	3	12	ER304.1.2	External angle	85%penetration
stainless steel3.5	1800	3000	100	30	3	12	ER304.1.2	plane	penetration
stainless steel3.5	1500	3000	100	30	3	12	ER304.1.2	interior angle	white
stainless steel3.5	1600	3000	100	30	3	12	ER304.1.2	External angle	85%penetration
stainless steel4.0	2700	3000	100	20	3.5	12	ER304.1.6	plane	penetration
stainless steel4.0	2000	3000	100	20	3.5	12	ER304.1.6	interior angle	color
stainless steel4.0	2500	3000	100	20	3.5	12	ER304.1.6	External angle	90%penetration
stainless steel5.0	3000	3000	100	15	4.0	12	ER304.1.6	plane	penetration
stainless steel5.0	2200	3000	100	15	4.0	12	ER304.1.6	interior angle	color
stainless steel5.0	2500	3000	100	15	4.0	12	ER304.1.6	External angle	85%penetration
stainless steel6.0	2600	3000	100	15	5	6	1.6		
stainless steel7.0	2800	3000	100	15	5	6	1.6		
stainless steel8.0	2950	3000	100	15	5	5	1.6		

二. stainless steel									
Material and thickness (mm)	laser power (W)	Laser Frequency (HZ)	Duty cycle (%)	Swing frequency (HZ)	Swing length (mm)	wire feeding speed (mm/s)	Welding wire model	welding angle	form
stainless steel1.0	500	3000	100	35	2	12	ER304.0.8	plane	penetration
stainless steel1.0	450	3000	100	35	2	12	ER304.0.8	interior angle	white
stainless steel1.0	500	3000	100	35	2	12	ER304.0.8	External angle	70%penetration
stainless steel1.5	550	3000	100	35	2	12	ER304.0.8	plane	penetration
stainless steel1.5	500	3000	100	35	2	12	ER304.0.8	interior angle	white

steel1.5								angle	
stainless steel1.5	550	3000	100	35	2	12	ER304.0.8	External angle	85%penetration
stainless steel2.0	700	3000	100	35	2.5	12	ER304.1.0	plane	penetration
stainless steel2.0	600	3000	100	35	2.5	12	ER304.1.0	interior angle	white
stainless steel2.0	700	3000	100	35	2.5	12	ER304.1.0	External angle	80%penetration
stainless steel2.5	850	3000	100	35	2.5	12	ER304.1.0	plane	penetration
stainless steel2.5	750	3000	100	35	2.5	12	ER304.1.0	interior angle	white
stainless steel2.5	750	3000	100	35	2.5	12	ER304.1.0	External angle	85penetration
stainless steel3.0	1300	3000	100	35	3.0	12	ER304.1.2	plane	penetration
stainless steel3.0	1100	3000	100	35	3.0	12	ER304.1.2	interior angle	white
stainless steel3.0	1300	3000	100	35	3.0	12	ER304.1.2	External angle	75%penetration
stainless steel3.5	1650	3000	100	30	3.0	12	ER304.1.2	plane	penetration
stainless steel3.5	1200	3000	100	30	3.0	12	ER304.1.2	interior angle	white
stainless steel3.5	1500	3000	100	30	3.0	12	ER304.1.2	External angle	85%penetration
stainless steel4.0	2400	3000	100	20	3.5	12	ER304.1.6	plane	penetration
stainless steel4.0	1800	3000	100	20	3.5	12	ER304.1.6	interior angle	yellowish
stainless steel4.0	2000	3000	100	20	3.5	12	ER304.1.6	External angle	85%penetration
stainless steel5.0	2700	3000	100	15	4.0	12	ER304.1.6	plane	penetration
stainless steel5.0	2100	3000	100	15	4.0	12	ER304.1.6	interior angle	color
stainless steel5.0	2300	3000	100	15	4.0	12	ER304.1.6	External angle	80%penetration
stainless steel6.0	2600	3000	100	15	5	7	1.6		
stainless steel7.0	2800	3000	100	15	5	5	1.6		
stainless steel8.0	2950	3000	100	15	5	4	1.6		

三. Galvanized sheet									
Material and thickness (mm)	laser power (W)	Laser Frequency (HZ)	Duty cycle (%)	Swing frequency (HZ)	Swing length (mm)	wire feeding speed (mm/s)	Welding wire model	welding angle	form
Galvanized sheet1.0	540	3000	100	20	2	12	ER304.0.8	plane	penetration
Galvanized sheet1.0	540	3000	100	20	2	12	ER304.0.8	interior angle	white
Galvanized sheet1.0	540	3000	100	20	2	12	ER304.0.8	External angle	70%penetration
Galvanized sheet1.5	690	3000	100	20	2	12	ER304.0.8	plane	penetration
Galvanized sheet1.5	660	3000	100	20	2	12	ER304.0.8	interior angle	white
Galvanized sheet1.5	690	3000	100	20	2	12	ER304.0.8	External angle	75%penetration
Galvanized sheet2.0	1200	3000	100	20	2.5	12	ER304.1.0	plane	penetration
Galvanized sheet2.0	1200	3000	100	20	2.5	12	ER304.1.0	interior angle	white
Galvanized sheet2.0	1200	3000	100	20	2.5	12	ER304.1.0	External angle	85%penetration
Galvanized sheet2.5	1500	3000	100	20	2.5	12	ER304.1.0	plane	penetration
Galvanized sheet2.5	1500	3000	100	20	2.5	12	ER304.1.0	interior angle	white
Galvanized sheet2.5	1500	3000	100	20	2.5	12	ER304.1.0	plane	80%penetration
Galvanized sheet3.0	1900	3000	100	15	3.0	12	ER304.1.2	plane	penetration
Galvanized sheet3.0	1700	3000	100	15	3.0	12	ER304.1.2	interior angle	white
Galvanized sheet3.0	1900	3000	100	15	3.0	12	ER304.1.2	External angle	85%penetration
四. aluminum alloy									
Material and thickness (mm)	laser power (W)	Laser Frequency (HZ)	Duty cycle (%)	Swing frequency (HZ)	Swing length (mm)	wire feeding speed (mm/s)	Welding wire model	welding angle	form
aluminum alloy1.0	600	3000	100	35	2	15	ER5356.0.8	plane	Double sided molding
aluminum alloy1.0	500	3000	100	35	2	15	ER5356.0.8	interior angle	white
aluminum alloy1.0	550	3000	100	35	2	15	ER5356.0.8	External angle	75%penetration
aluminum alloy1.5	750	3000	100	35	2.5	15	ER5356.0.8	plane	Double sided molding
aluminum alloy1.5	650	3000	100	35	2.5	15	ER5356.0.8	interior angle	white
aluminum alloy1.5	700	3000	100	35	2.5	15	ER5356.0.8	External angle	75%penetration
aluminum alloy2.0	1050	3000	100	35	2.5	15	ER5356.1.0	plane	Double sided molding
aluminum alloy2.0	900	3000	100	35	2.5	15	ER5356.1.0	interior angle	white
aluminum alloy2.0	950	3000	100	35	2.5	15	ER5356.1.0	External angle	85%penetration
aluminum alloy2.5	1260	3000	100	35	2.5	15	ER5356.1.0	plane	Double sided molding
aluminum alloy2.5	1000	3000	100	35	2.5	15	ER5356.1.0	interior angle	white
aluminum alloy2.5	1100	3000	100	35	2.5	15	ER5356.1.0	External angle	80%penetration
aluminum alloy3.0	1500	3000	100	35	3.5	10	ER5356.1.2	plane	Double sided molding
aluminum alloy3.0	1050	3000	100	35	3.0	15	ER5356.1.2	interior angle	white

aluminum alloy3.0	1200	3000	100	35	3.0	15	ER5356.1.2	External angle	penetration80%
aluminium4.0	1700	3000	100	20	3.5	12	1.6		
aluminium5.0	2200	3000	100	18	4	12	1.6		
aluminium6.0	2500	3000	100	15	4	10	1.6		
aluminium7.0	2700	3000	100	15	5	8	1.6		
aluminium8.0	2950	3000	100	15	5	5	1.6		