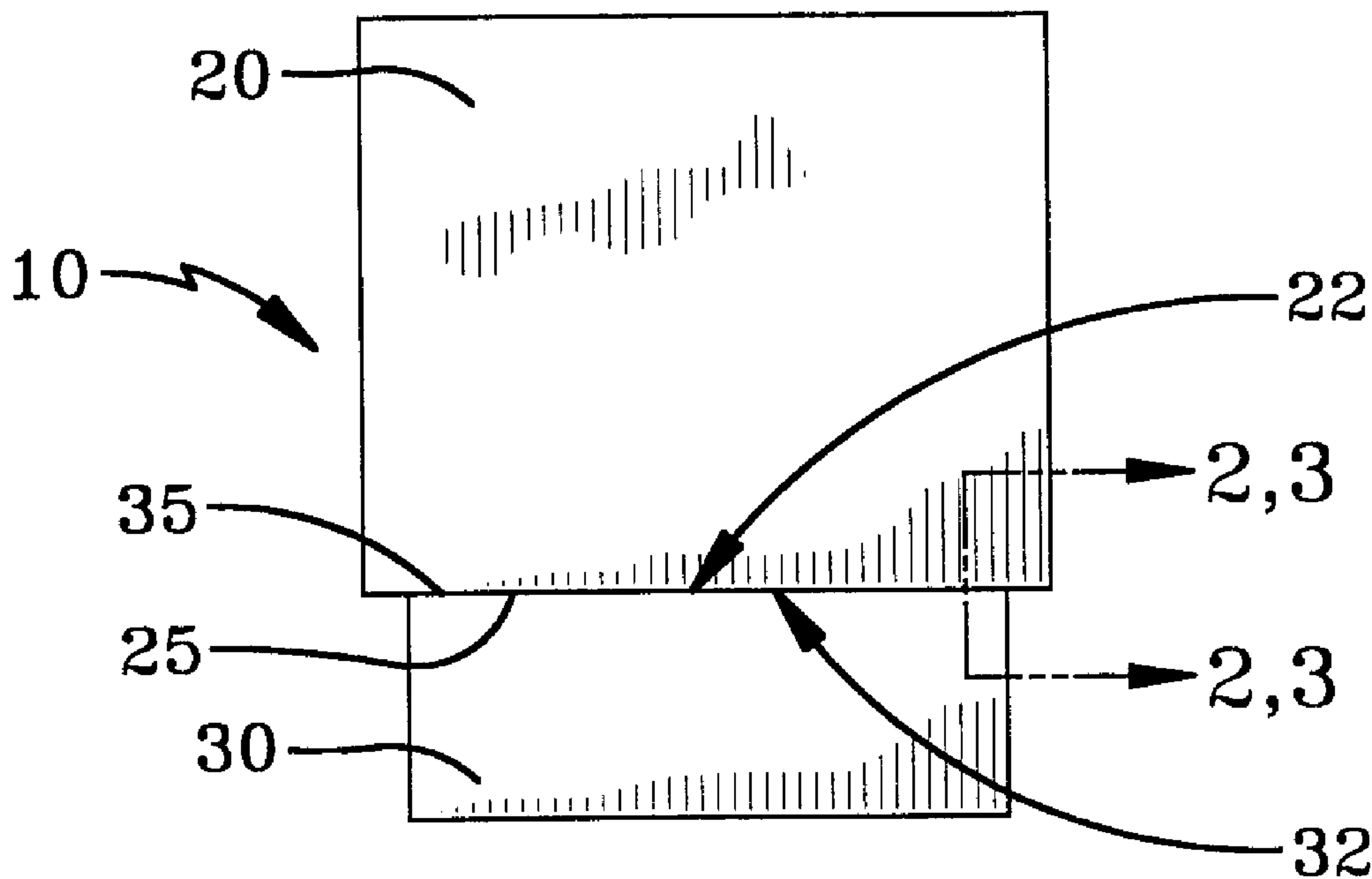




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 (71) Demandeur/Applicant:
HONDA GIKEN KOGYO KABUSHIKI KAISHA, JP
 (72) Inventeurs/Inventors:
GODSIL, FRANK, US;
MORRIS, DARIN, US;
FOLEY, JAMES, US;
FIELDS, DONALD R., JR., US
 (74) Agent: SMART & BIGGAR

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(57) Abrégé/Abstract:

The present invention relates generally to an improved laser welded work piece, such as an automotive body panel, and a system and method for the manufacture thereof. The invention is also directed to an improved system for manufacturing the welded work piece including an improved laser welder and a laser weld inspection device and system.

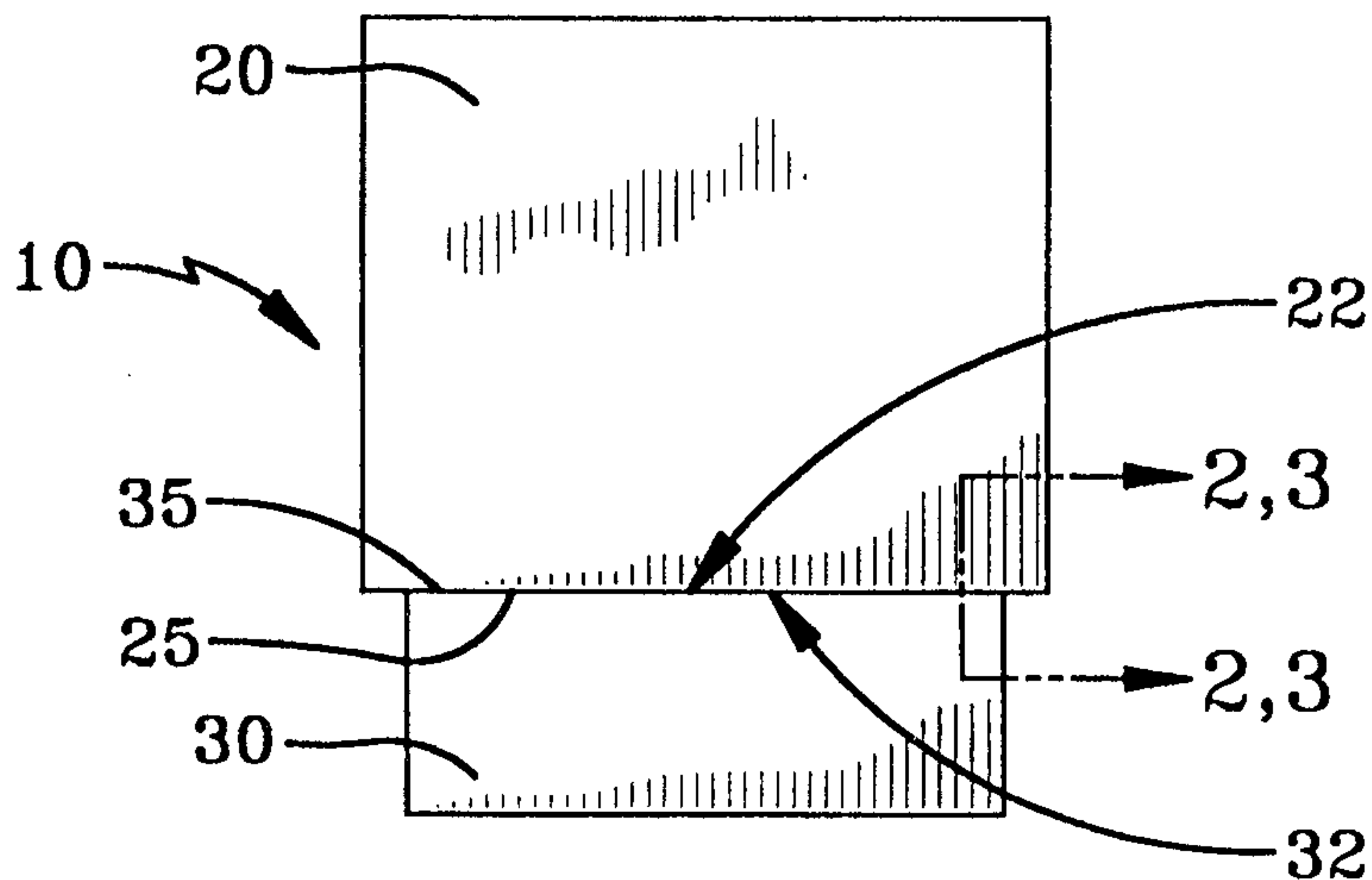
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(54) Title: LASER WELDING SYSTEM**(57) Abstract**

The present invention relates generally to an improved laser welded work piece, such as an automotive body panel, and a system and method for the manufacture thereof. The invention is also directed to an improved system for manufacturing the welded work piece including an improved laser welder and a laser weld inspection device and system.



LASER WELDING SYSTEM

BACKGROUND OF THE INVENTION

Field of the Invention

The present invention relates generally to a new automated laser welding system configured to produce, for example, an improved welded work piece, such as an automotive body panel, and a system and method for the manufacture thereof that includes an improved laser welder and a visual weld inspection device. The invention also relates to a method for performing an automated quality control inspection of a laser weld.

Background

10 In the past, welded work pieces such as body panels for use in the automotive vehicle industry were made by stamping or drawing the panel from either a single blank of a ductile sheet metal material, including steel, or from a plurality of such blanks that were previously welded together. Either type of welded work piece or body panel usually required the addition of stiffeners and pads welded to sections of the panel to improve its structural rigidity. The added stiffeners and pads were also needed to increase the thickness of the work piece in predetermined locations so that various structural and fastening assemblies could be fastened and welded to the panel without damage during the fastening or welding process. The addition of the stiffeners and pads increased the weight of the work piece and also increased the total manufacturing time needed to fabricate the work piece. The work pieces were often formed, drawn, or stamped into a final shape to have a three-dimensional shape corresponding to the overall design of the automotive vehicle.

As a result of the number of manufacturers in the field, the automotive vehicle industry is very competitive with respect to, among other things, quality, raw material costs, and manufacturing times required to completely fabricate and assemble a vehicle. To remain competitive, manufacturers have continuously expended
5 enormous resources to contain, if not reduce, material costs by reducing part weight, part count, and manufacturing time while maintaining the needed high degree of quality. A considerable amount of such resources have been directed to improving and automating routine tasks such as the fastening together of various work pieces and vehicle parts such as, for example, body panels for fenders, quarter panels, trunk lids,
10 engine compartment hoods, vehicle doors, and other various components.

Previously, multi-part sheet metal blanks have been welded together into a single work piece before being stamped into a final shape. These blanks were prepared by a variety of fastening techniques including chemical, arc, and CO₂ laser welding, riveting, bolting, cold forming, and similar methods. Of particular interest in
15 recent years is the use of more efficient laser welding using CO₂ lasers in automated, numerically controlled manufacturing processes. Such laser welding can be accomplished for joining together sheet metal blanks at a common seam by means of, for example, a lap weld, or a butt weld. Butt welds are often preferred because only a single seam needs to be welded in contrast to lap joint which usually require that two
20 seams be welded.

Many problems have been associated with the use of CO₂ lasers including the requirement that less than optimum welding speeds must be used because of the poor absorption by steel work pieces of the energy produced by the CO₂ laser. Also, laser welded joints can be plagued with problems despite the use of an appropriate weld
25 speed if a manufacturer does not carefully prepare the work pieces or is otherwise not attentive to the intricacies and pitfalls of laser welding processes. Problems are even more prevalent when the blanks to be welded together are of dissimilar thickness.

Such problems include, for example, mismatch between the welded parts along the joint on at least one exterior surface, poor weld bead dimensions or hardness, cracks, poor weld bead continuity across the length of the weld, and pinholes formed in the weld bead. Many of these welding problems are difficult to avoid and even more
5 difficult to detect. More often than not, detection of such problems can only be accomplished by a slow and tedious visual inspection. Further, some of these problems, such as cracks, weld spatter, and pinholes, can only be detected through destructive testing such as by tension and shear tests, micrographic cross-sectional analysis, etch and penetrant dye inspections, and formability testing to ensure the
10 welded blanks of the work piece can be drawn or stamped without failure anywhere along the welded joint.

These problems are especially apparent when steel work pieces, such as welded components for an automotive body or door panel, are to be butt welded together for form a larger, single work piece or door panel blank that can be later
15 stamped or drawn into a shaped panel ready for painting and attachment to the vehicle. In many cases such welds are straight line weldments that could be completed faster if an improved laser welding technique were available. Additionally, it would be desirable to have an automated manufacturing assembly line wherein multiple work pieces could be automatically introduced to the laser welding apparatus
20 to minimize the risk of injuries to workers from reflected laser energy. Further, such welding manufacturing processes could be made more efficient if a technique existed to speed up the post-weld inspection process.

There have been attempts to develop a viable method for laser welding inspection. United States Patent No. 5,607,605 discloses such a method, which
25 utilizes a CCD (Charge Coupled Device) camera to capture an image of the plasma generated when a laser beam contacts an object to be welded. The image is then sent to an image processing device, which measures a selected particular feature of the

plasma cloud. The measurement is further transferred to a distinction device, which compares the measurement with a reference value to determine if the laser welding condition, and thus the weld, is acceptable.

Electro-optical detection of laser welding conditions has also been employed
5 as an inspection method. United States Patent No. 5,272,312 recites a method for the inspection of a laser weld, wherein the area of the material in contact with the laser beam, referred to as the laser processing spot, is projected onto at least one photodetector such as photodiode which detects the amount of liquid material ejected from the weld pool during the welding process. The signal from the photodiode can
10 be converted into an electrical signal, which may then be sent to a processing unit for determination of the size and location of voids or pores in the weld seam. In one embodiment, this reference discloses the detection of ultraviolet radiation present in the plasma cloud.

Laser welding generates particular signals which may be monitored to
15 determine the quality of a weld. United States Patent No. 5,681,490 discloses that sensors such as photodiodes, phototransistors, photo darlington, pyroelectric detectors, microphones, and infrared and thermal detectors can be positioned to monitor various stages of the welding process. Such sensors may be utilized to monitor light, sound, gas, smoke, temperature, etc. The signals generated by these
20 sensors may then be analyzed by a computer to predict the weld quality.

None of the prior art, however, discloses an apparatus or method utilizing direct inspection of the weld bead to determine the quality of a laser weld. The prior art methods generally depend upon the use of unstable process indicators to ascertain the condition of the weld, often requiring the monitoring and analysis of a multitude
25 of signals to reach a conclusion regarding weld quality.

The automotive industry is in need of a laser welded work piece that contains fewer parts, has an optimally minimized weight, and that is produced through the use of

an automated, laser welding manufacturing process. The welded work piece produced in accordance with the present invention, and the system and method for its manufacture, overcomes the deficiencies of the presently known methods for automated laser welding and inspection of welded work pieces.

5

SUMMARY OF THE INVENTION

In general, the present invention is directed to an improved laser welded work piece and an automated laser welding and visual inspection system and method configured to manufacture the work piece. The welded work piece incorporates a minimized gap that is designed to improve the structural properties of the laser weld. The new automated manufacturing system includes a robotically automated production line configured to prepare blank work pieces for welding by precision shearing at least one edge, and to precisely align the blanks and laser weld them together using a single or dual cell, high-speed, high-power laser. During welding, the laser weld is concurrently inspected by a visual inspection device to determine whether the welded work piece should be accepted or rejected. The operator can continuously supply palletized raw materials, such as pallets or skids of sheet metal blanks, to the production line without stopping or interrupting the automated production line. After welding, the system robotically sorts and re-palletizes the finished, welded work piece onto accepted work piece skids or onto rejected work piece skids. The operator can remove the accepted and rejected work pieces from the production line without stopping or interrupting the continuously running line.

25

THE WELDED WORK PIECE

The invention includes a welded work piece for use in manufacturing an automotive vehicle that incorporates a first blank of a steel sheet stock with a first thickness and having at least one first precision sheared edge, and a second blank

formed from a steel sheet stock material of a second thickness having at least one second precision sheared edge. The first and second precision sheared edges are produced in the respective first and second blanks to form a minimized gap between the edges before welding. The edges are laser welded using the apparatus disclosed herein, to form a beaded seam that permanently joins the respective first and second blanks. In a method for manufacturing the improved welded work piece, first and second blanks of a sheet stock steel are selected to be of similar or dissimilar respective thickness and respective precision sheared edges. The edges are positioned on a flat welding surface and tightly compressed together in an abutting relationship to form a minimized gap between the edges. The edges are then laser welded together to form a beaded seam that permanently joins the blanks together to form the welded work piece.

There is thus disclosed a welded work piece for use in manufacturing an automotive vehicle, comprising first and second sheet metal blanks, each formed with at least one precision sheared edge and having similar or dissimilar thickness. The blanks form a minimized gap when the respective at least one precision sheared edges are positioned in an abutting relationship. A continuous wave laser butt welded seam fixedly joins the blanks together along at least one of the respective precision sheared edges.

20

THE SYSTEM

Another aspect of the present invention is directed to a system for manufacturing a welded work piece. The system includes at least one articulating arm feeder robot, configured to retrieve at least one sheet metal blank from a plurality of such blanks, from at least one of a plurality of feeder skids containing palletized sheet metal blanks. The arm is adapted to transport the individual blanks, one at a time, from the skid to a load position on a magnetic conveyor. Each of the blanks are

25

formed with at least one joining edge. In applications where blanks of dissimilar thickness or other dimensions are used, the blanks may either be stacked alternately on a single skid, or a second articulating arm feeder robot may be employed to retrieve a dissimilar blank from a second plurality of such blanks that are palletized on a second plurality of skids. The second robot arm operates cooperatively to feed the second, dissimilar blank onto the magnetic conveyer.

The magnetic conveyer of the system is adapted to receive from the feeder robot or robots at least two blanks. The conveyer is configured with blank locator devices adapted to precisely position them on the substantially flat conveyer bed. The blanks are proximally pre-positioned so each of the respective joining edges are substantially parallel. The magnetic conveyer is further configured to releasably restrain the positioned blanks into place and to move the blanks from the load position to a shear position.

The system also incorporates a precision shear device positioned about the shearing position of the magnetic conveyer. The shear device is configured with at least one upper stamping die that cooperates with at least one lower stamping platen to precisely shear at least one of the respective joining edges of each of the blanks. After shearing, the blanks are moved by the magnetic conveyer onto an idle station that temporarily stores the sheared blanks until they can be welded. The blanks are then conveyed by a second conveyer to a welding gantry located at the other end of the idle station.

The second conveyer moves the sheared blanks onto a laser weld bed of the welding gantry. The gantry includes a clamping and positioning assembly operative to releasably register and press the respective joining edges of the blanks flat against the weld bed and tightly together with the edges in an abutting relationship to form a minimized gap. The clamping mechanism is configured with a clamp assembly having multiple bars that clamp down on each blank to firmly press them against the

laser weld bed. The positioning assembly includes a plurality of locator assemblies that push against one or more of the non-joining edges of each blank to precisely locate the blanks so that the precision sheared edges are tightly pressed together. When so pressed together, the edges form a minimized gap or seam therebetween.

5 The system also includes a laser welder movably attached to the welding gantry. The laser welder may be configured with a weld head powered by a remote laser power unit. The weld head moves along the gantry and, when energized, projects a laser beam incident to and focused upon the gap or seam of the blanks to form a weld bead seam. The system also comprises a laser weld inspection device
10 that is adapted to move along either in conjunction with or independently of the laser weld head to inspect to the weld bead seam. Once welded, an exit conveyor operates to remove the welded work piece from the laser weld bed. An articulating arm exit robot is also included that is configured to move the work piece from the exit conveyor to an exit station. If the inspection revealed that the weld was acceptable,
15 the exit robot moves the welded work piece to one of a plurality of skids for work pieces that have passed the inspection. Otherwise, if the inspection revealed that the weld bead seam was not acceptable, the exit robot moves the defective welded work piece to one of a possible plurality of reject skids.

 There is thus disclosed a system for manufacturing a welded work piece,
20 comprising at least one articulating arm feeder robot, configured to retrieve at least one blank from at least one of a plurality of feeder skids of palletized sheet metal blanks. Each blank is formed with at least one joining edge, and the articulating arm feeder robot is adapted to transport the blank to a load position on a magnetic conveyor. The magnetic conveyor is adapted to receive from the feeder robot or
25 robots at least two of the plurality of blanks and to precisely position them on a conveyor bed. The blanks are proximally pre-positioned so each of the respective joining edges are substantially parallel, and the magnetic conveyor is further

configured to releasably restrain the positioned blanks into place and to move them from the load position to a shear position. The system further comprises a precision shear device, positioned about the shearing position of the magnetic conveyer, and configured with at least one upper stamping die that cooperates with at least one lower stamping platen to precisely shear at least one of the respective joining edges. There is also a welding gantry, spaced apart from the precision shear device and configured with a second conveyer having a laser weld bed and connected to the magnetic conveyer with an idle station therebetween. The second conveyer is configured to slidably receive the sheared blanks from the idle station and to move them onto the laser weld bed. The system also utilizes a clamping and positioning assembly operative to releasably register and press the respective joining edges of the blanks flat against the weld bed and tightly together in an abutting relationship to form a minimized gap. A laser welder is movably attached to the welding gantry, and has a weld head powered by a remote laser power unit to project a laser beam incident to and focused upon the gap for welding the blanks along the gap to form a weld bead seam. A laser weld inspection device is slidably coupled to the welding gantry and operative to inspect the weld bead. After inspection, an exit conveyer coupled to the second conveyer, removes the welded work piece from the laser weld bed. An articulating arm exit robot moves the work piece from the exit conveyer to an exit station, which is selected from the group of one of a plurality of accepted work piece skids or a rejected work piece skid.

The system further includes a light curtain system that is configured to surround each of the plurality of the feeder and exit station skids to allow removal and replacement of empty feeder and full exit skids without the need to interrupt the operating manufacturing system. If an operator approaches any of the skids for removal and replacement, the light curtains signal the robots either directly or indirectly. In response, each of the robots is directed to another of the plurality of

skids for purposes of retrieving unwelded blanks or outputting welded work pieces during the period of time that the light curtain is activated. Similarly, each of the skids or a skid holder unit incorporates a sensor that either signals that the skid is empty or full. If either of these conditions occurs, the robot is directed to use another
5 of the plurality of skids.

There is further disclosed a method for manufacturing a welded work piece comprising the steps of: shearing a precision edge on a respective joining edge of a plurality of sheet metal blanks, using a precision shear device configured with at least one upper stamping die that cooperates with at least one lower stamping platen to
10 perform the shearing operation; moving the plurality of precision sheared blanks together on a conveyor from the precision shear device to a laser weld bed of a welding gantry; precisely locating the blanks to register the precision sheared edges in a compressed, abutting relationship; clamping the respective joining edges of the blanks flat against the weld bed and tightly together in an abutting relationship to
15 form a minimized gap; and laser welding the edges to form a beaded seam and to permanently join the blanks together.

THE LASER WELDER

In yet another aspect of the present invention, a single or multi-celled laser
20 welder is described. The laser welder incorporates at least one laser weld head that is configured to movably project at least one laser beam onto a plurality of work pieces to weld them together. As described above, the work pieces are positioned so that the edges are tightly pressed together in an abutting relationship to form a seam or gap. The work pieces are welded together with a laser weld head that projects the laser
25 beam incident to the gap with a compound angle. The compound angle is measured relative to the vertical direction substantially normal to the substantially flat sheet metal work pieces. A leading angle component of the compound angle is

substantially in the direction of movement of the laser weld beam as the weld head moves across the blanks during welding. A leaning component of the compound angle is orthogonal to the leading angle and is substantially in the direction normal to the blanks and the gap and it leans to one side towards one of the blanks away from the vertical direction.

Thus, there is disclosed a laser welder for welding a plurality of work pieces, comprising a laser weld head configured to movably project a laser beam onto a minimized gap formed between a plurality of adjacent, substantially flat work pieces formed with respective precision sheared edges. The edges are positioned in an abutting relationship, and the laser weld head is operative to weld the edges by forming a weld bead seam between the edges. The laser welder further comprises a laser beam incident on the gap with a compound angle. The compound angle is measured relative to the vertical direction substantially normal to the work pieces, and includes a leading angle component substantially in the direction of movement of the laser weld beam, and a leaning component substantially in the direction normal to the gap and leaning towards one of the blanks away from the vertical direction.

There is further disclosed a multi-celled laser welder comprising a plurality of laser weld heads, each configured to movably project a laser beam onto a plurality of minimized gaps formed between a plurality of adjacent, substantially flat work pieces formed with respective precision sheared edges. The edges are positioned in an abutting relationship and the laser weld heads are operative to weld the edges by forming a weld bead seam between the edges. The laser beams are incident on the gaps with a compound angle. The compound angle is measured relative to the vertical direction substantially normal to the work pieces, and includes a leading angle component substantially in the direction of movement of the laser beams and a leaning component substantially in the direction normal to the gaps and leaning towards one of the blanks away from the vertical direction.

THE INSPECTION SYSTEM

The present invention is also directed to a specially designed vision system configured to inspect a laser weld bead in real time. When the focal point of a laser beam contacts a work piece, it generates intense heat which forms a molten weld pool. As the laser beam traverses the work piece, the weld pool left behind quickly cools to form a weld bead. A visual sensor, such as a CCD (Charge Coupled Device) or video camera follows the laser welding head to view the weld bead. Although in a preferred embodiment of the invention a visual sensor is affixed to and travels with the laser welding head, it should be realized that the visual sensor could also be detached and independently propelled. An image of the weld bead is captured by the visual sensor at a predetermined interval based on the velocity of the laser welding head and other factors. The image from the visual sensor is sent to an image processing board, which in conjunction with a coprocessor board, computer and the system software, compare the image to a list of predefined, preferred tolerances, which correlate with several established characteristics of the weld bead considered to be acceptable. If it is determined that the selected characteristics of the weld bead image are within the specified predefined tolerance limits, a signal is generated classifying the weld as acceptable. If it is determined that the image is outside the specified predefined tolerance limits, a signal is generated classifying the weld as defective.

Thus, there is disclosed a laser welding inspection system comprising a laser welding device, an image capturing device for capturing the image of a laser weld bead, and an image processing device in electronic communication with the image capturing device, for measuring at least one dimension of the laser weld bead image captured by the image capturing device. The system further comprises a distinction device, in electronic communication with the image processing device, for comparing the value of the at least one dimension of the laser weld bead image measured by the

image processing device with a reference value, to determine the quality of the laser weld.

There is further disclosed a method of inspecting a laser weld, the method comprising capturing an image of a weld bead, measuring at least one dimension of the laser weld bead image, and comparing the value of the dimension of the laser weld bead image with a reference value to determine the quality of the laser weld.

Other features and advantages of the invention will become apparent from the following detailed description, taken in conjunction with the accompanying drawings, which illustrate, by way of example, the features of the present invention.

10

BRIEF DESCRIPTION OF THE DRAWINGS

Without limiting the scope of the present invention as claimed below and referring now to the drawings, wherein like reference numerals across the various views refer to identical, corresponding, or equivalent features and parts:

15 FIG. 1 is a planform view, in reduced scale, of a preferred embodiment of a welded work piece produced in accordance with the present invention;

FIG. 2 depicts a rotated, partial, cross-sectional view taken along section line 2-2 of FIG. 1, in enlarged scale, of the work piece of FIG. 1 before welding;

20 FIG. 2a depicts a dimensional representation of an illustrative example of the work piece of FIG. 2;

FIG. 3 is a rotated, partial, cross-sectional view taken along section line 3-3 of FIG. 1, in enlarged scale, of the work piece of FIG. 1 after welding;

FIG. 3a is a schematic representation of another embodiment of the work piece of FIG. 3;

25 FIG. 3b is a schematic representation of another embodiment of the work piece of FIG.3 wherein the lower surfaces of the welded work piece are misaligned;

FIG. 4 is an elevated perspective view, in reduced scale, of a stamped body panel fabricated from the welded work piece of FIG. 1;

FIG. 5 is schematic top-view, in reduced scale, of the layout of a system for manufacturing the laser welded work piece of the present invention;

5 FIG. 6a is a schematic, rotated front-view taken along section line 6-6 of FIG. 5, in enlarged scale, of a representative laser welder gantry, a laser welder, and a laser weld inspection device;

FIG. 6b is a detail view, in enlarged scale, of a portion of FIG. 6a and showing the leading angle component of the compound angle of the laser beam;

10 FIG. 6c is a section view taken along line 6c-6c of FIG. 6b and showing the leaning angle component of the compound angle of the laser beam;

FIG. 7 is a flow diagram representative of an exemplary embodiment of the comparison procedure used by the control computers or the laser weld inspection device, or both, of FIGS. 5, 6a, and 6b;

15 FIG. 8 is an enlarged view of a portion of FIG. 5 representing a plurality of the feeder skids, feeder robot arm, and light curtains of the manufacturing system of the present invention;

FIG. 9 is an enlarged view of a portion of FIG. 5 representing a plurality of the feeder skids, feeder robot arm, part of the magnetic conveyor, and part of the precision
20 shear machine of the manufacturing system of the present invention;

FIG. 10 is an enlarged view of a portion of FIG. 5 representing a second conveyer, a weld gantry, a laser weld head, and work piece locators of the manufacturing system of the present invention; and

FIG. 11 is an enlarged view of a portion of FIG. 5 representing an exit conveyer,
25 an exit robot arm, and a plurality of accepted work piece skids and a rejected work piece skid of the manufacturing system of the present invention.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

The invention produces an improved welded work piece that is welded from a plurality of sheet metal blanks of substantially similar or dissimilar thickness, which are formed from materials such as steel, aluminum, and alloys. According to the invention, the plurality of blanks are laser welded together at speeds faster than previously possible with a much lower percentage of rejected work pieces. Before welding, the blanks are precision sheared along at least one joining edge. The precision shear ensures that when the sheared edges of the blanks are placed in an abutting relationship, a minimized gap, if any at all, will exist. The closely toleranced and minimized gap improves the final weldment and reduces the time needed to complete the manufacturing process.

With reference to FIG. 1, an improved work piece **10** is shown having a first sheet metal blank **20** and a second sheet metal blank **30**. The blanks **20**, **30** each have at least one joining edge **22**, **32** each formed with a precision sheared edge **25**, **35**, respectively. Prior to butt welding, the blanks **20**, **30** are pressed flat onto a welding surface (not shown) with the precision sheared edges **25**, **35**, pressed tightly together. As can be understood with reference to FIGS. 2 and 2a, when the edges **25**, **35** are so positioned, they are ideally in facing contact with one another over the entire length of the interface between them. However, under even the most controlled and the most tightly toleranced of manufacturing conditions, uninterrupted contact of the edges **25**, **35** is unachievable, and some gaps **38**, although very small, are experienced at the interface of the edges **25**, **35**. These gaps **38** are due to the normal manufacturing tolerances encountered with the manufacturing process and are always experienced during production. In the preferred embodiment, the gaps **38** between precision sheared edges **25**, **35** are preferably between approximately zero and approximately 0.08 millimeters and more preferably less than 0.04 millimeters.

These gaps **38** can cause problems with welded joints such as butt welds. This is because the gaps **38** can lead to less than optimum welds due to the development of macroscopic and microscopic cracks and micropores, among other irregularities and anomalies, in the weldment between the joining edges **22, 32**. If not properly
5 accounted for in the design, strength analysis, and manufacturing process, or if not otherwise minimized during the manufacturing process, these types of irregularities and anomalies can lead to increased numbers of rejected welded work pieces **10**.
Despite such anomalies and irregularities, the gaps **38** can be significantly minimized during the manufacturing process which, in turn, substantially reduces the number of
10 rejected work pieces **10**. The gaps **38** are minimized by precision shearing the joining edges **22, 32**, to achieve the above gap dimensions, before welding. FIGS. 3, 3a, and 3b schematically represent the welded interface or weldment **40**. The preferred characteristics of the weldment are described below with respect to the discussion of the laser weld inspection device of the present invention.

15 The preferred embodiment of a welded work piece produced in accordance with the present invention includes blanks **20, 30** of substantially similar or dissimilar thickness. For purposes of illustration but not limitation, the thickness for each blank **20, 30** can range preferably from between approximately 0.4 millimeters to approximately 2.0 millimeters, and more preferably from between approximately 0.7
20 millimeters to approximately 1.4 millimeters. In one embodiment of the invention, one blank thickness is between approximately 0.50 millimeters and approximately 0.75 and the other blank thickness is between approximately 1.25 millimeters and approximately 1.50 millimeters. As an example of such dissimilar thickness, the first blank **20** can be selected to have a thickness of approximately 0.7 millimeters while
25 the second blank **30** can be selected to have a thickness of approximately 1.4 millimeters. Many various thickness arrangements of first and second blanks **20, 30** are possible. The preceding example is particularly effective for use in manufacturing

a welded work piece suitable for applications where increased rigidity must be imparted to a portion of the work piece. This example is especially efficient in applications where the added rigidity must be accomplished without a corresponding increase in the part count or the part weight, as would occur if stiffeners, pads, or
5 other structural supports were added to the work piece.

Although representative dimensions are set forth, they are presented only for purposes of demonstrating a particular embodiment of the present invention and not for purposes of limitation. One having ordinary skill in the art will understand that various types and thicknesses of steel, steel alloy, and other metal materials, are contemplated
10 for use with the present invention.

As a further illustrative example, the usefulness of the preferred embodiment is readily apparent in aeronautical or automotive applications. In aeronautical applications, structural rigidity must be accomplished with minimum possible weight and part count to minimize the overall aircraft weight and manufacturing cost.
15 Similarly, in automotive manufacturing, where millions of copies of the same part are fabricated, minimized weight and part count can translate into substantial savings in material costs and manufacturing times. With reference to FIG. 4, a representative preferred embodiment of the improved welded work piece is shown as applied to the fabrication of a drawn or stamped body panel **50** configured for use in the automotive
20 vehicle manufacturing industry. First and second blanks **20'**, **30'** are welded together along weld seam **40'** after precision shearing the respective joining edges. The improved welded work piece is then stamped or drawn into the desired shape of an automotive vehicle body panel.

SYSTEM DISCLOSURE

The present invention also provides a significant improvement over previously known welded work pieces and the system and method for their manufacture. With reference to FIG. 5, the invention includes an automated welded work piece manufacturing system **100** configured to robotically retrieve a plurality of blanks, to form at least one respective precision sheared edge on the blanks, to weld the blanks together, to inspect the weldment, and to robotically output the satisfactorily welded work pieces to an accepted station and the improperly welded work pieces to a rejected station.

10 The blanks to be welded are fed to the automated manufacturing system **100** by at least one of plurality of articulating arm feeder robots. The automated manufacturing system **100** includes one or more control computers **105** configured to communicate with, monitor, and/or control the various subsystems and components of the system **100**. With reference to FIGS. 5 and 9, also included is at least one of a plurality of robotic stations that preferably include at least a first robotic feeder station **110** that incorporates a first articulating arm feeder robot **120** that is capable of variable operation speeds and of 1, 2, or 3 dimensional motion with articulation about substantially 2 to substantially 5 axes each ranging between approximately 5 to approximately 360 degrees. Although not required for purposes of the preferred embodiment, each robot may also incorporate a vertical and horizontal telescoping capability for added flexibility. The first robot **120** further includes a manipulator **125** configured to releasably capture a first sheet metal blank **130** of a plurality of blanks **135** for transport between at least two positions. Many types of suitable robots are commercially available and include the Model SK-120 industrial robot available from Motoman, Inc., of West Carrolton, Ohio.

25 Preferably, the first robot **120** retrieves the blank **130** from at least one of a first plurality of feeder pallets or skids **140** containing the plurality of palletized blanks **135**. Typically, the first robot is configured to empty one skid at a time and then to begin

removing blanks from the next available skid. The first robot **120** can be configured to retrieve a predetermined number of blanks **130** from the skid **140** before it begins to retrieve blanks **130** from the next available skid **140**. Alternatively, the skids **140** themselves may be configured to detect a low quantity or empty skid. To accomplish this, each of the skids **140** includes a quantity detector assembly **145** adapted to determine whether the quantity of remaining blanks **130** is low or zero, or both, by using either a light sensor, a weight detector, or a video system, or some combination thereof. Upon determining a low or zero quantity, the detector assembly **145** signals either the first robot **120** or any of the control computers **105**. In response, either the first robot **120** or any of the control computers **105** can take a selected skid **140** out of service and initiate retrieval of blanks **130** from the next available skid **140**. For purposes of alerting supervisory personnel of the need to refill the empty skid **140**, the detector assembly **145** can be adapted to also generate a visual, audible, or electronic alarm or signal. In a modification to the preferred embodiment, the quantity detector assembly **145** can be adapted for attachment to the manipulator **125** of the first robot **120** so that the detector assembly **145** detects low or empty skids **140** when it attempts to capture and retrieve the next blank from the skid.

For safety purposes, the first robotic feeder station **110** is substantially surrounded by a safety fence or partition **150** configured with light curtain assemblies or specially adapted doors, or both, to detect intrusions into the work area of the first robotic feeder station **110**. The partition **150** incorporates a plurality of spaced apart light curtain sensors **155** operative to signal an alarm when an intrusion occurs. These types of sensors are commercially available from many vendors including Scientific Technologies, Inc. of Fremont, California. The alarm is selected to be either visual, acoustic, or electronic, or a combination thereof. The alarm, in turn, is configured to generate one or more resulting alerts. First, the alarm can visually or audibly warn an individual intruder or supervisory personnel of the presence of an intrusion into the

potentially dangerous area adjacent to the first robot **120**. Also, the alarm can electronically signal the first robot **120** or any of the control computers **105**, or both, that an intrusion of the first robotic feeder station **110** has occurred. If an intruder has entered the first station **110** work area, then either the first robot **120** or one of the control computers **105**, or both, can generate further alarms. The first robot **120** can also be configured to completely cease operation to prevent injury to the intruder. Similarly, any of the control computers **105** can be configured to stop the first robot **120** from operating, and can further stop the entire system **100** from operations so the intruder can safely exit the first station **110**.

Additionally, the light curtain partition **150** includes spaced apart light curtain skid removal sensors **160** proximate to each of the feeder skids **140** of palletized blanks **135**. The removal sensors **160** are configured to operate in cooperation with the quantity detector assemblies **145** and to communicate a skid removal alert signal to either the robot **120** or any of the control computers **105** when an operator approaches and engages any of the feeder skids **140** for removal of the empty or low quantity skid **140** and replacement with a full skid **140**. When a skid **140** has already been identified as empty or low, the removal sensor **160** can be adapted to generate the skid removal signal or to remain silent. Also, even if the detector assembly **145** has not generated a skid low or empty alert signal, the skid removal sensor **160** is configured similarly to the detector assembly **145** to alert the first robot **120** or any of the control computers **105** that blanks **130** must be retrieved from the next available skid **140**. Thus, an operator can easily remove and replace any skid **140** that is low or empty. When a skid removal alert signal is generated, the first robot **120** is configured to retrieve blanks **130** only from one of the other skids **140** of the plurality. In this way, the system **100** can continue full speed operations while empty or low skids are replaced with full skids.

As depicted in FIGS. 5 and 9, the system **100** may include a second robot feeder station **170** configured with some or all of the capabilities of the first robotic

feeder station **110** including, for example, a second robot **175**. For purposes of illustration but not limitation, the second station **170** is spaced adjacent to or apart from the first station **110**. It can include, for example, each or combinations of the components, assemblies, and capabilities of the first station **110**. The second station **170** is configured to retrieve a second sheet metal blank **180** from a plurality of palletized blanks **185** that are stored on a plurality of feeder skids **190**. As before, the skids **190** have some or all of the elements of the feeder skids **140**. The blanks **180** may have a thickness similar or dissimilar to the blanks **130**.

The one or more robotic stations **120**, **175** are located proximal to a precision conveyer assembly **200** that incorporates a precision shearing machine **210**, as can be understood with reference to FIGS. 5, 8, and 9. The precision conveyer assembly **200** may be configured with a substantially flat bed or a pre-shaped support jig **215** and plurality of precision sub-conveyors **220**, **225** configured to precisely locate relative to one another, a plurality of work piece blanks such as blanks **130**, **180**. The precision conveyer **200** is adapted to releasably restrain the received blanks **130**, **180** after they are received from the robotic feeder stations **110**, **170**. The restraint mechanism may include a plurality or combination of vacuum, magnetic, or clamping devices arranged on a conveyer bed **230** about the conveyer assembly **200** or sub-conveyors **220**, **225** to releasably capture the blanks **130**, **180**. After receipt and capture of the blanks, the conveyer assembly **200** or sub-conveyors **220**, **225** precisely position the blanks **130**, **180** relative to each other and move them into a machining or shearing position proximal to the precision shearing machine **210**. The conveyer assembly **200** or sub-conveyors **220**, **225** each include actuatable locator assemblies **228** arranged about the conveyer bed **215** that are operative to engage or push against one or more of the exterior sides of the blanks **130**, **180** to orient and position the blanks relative to each other and the shearing machine **210** with the joining edges of the blanks **130**, **180** arranged in a facing and substantially parallel relationship. The locator assemblies **228**

are preferably actuated with air-cylinders or any or a wide variety commercially available industrial air, pneudraulic, and hydraulic systems . Many suitable conveyors having such positioning assemblies are available from a number of commercial suppliers and a magnetic conveyor suitable for use as the above configuration is
5 available from VIL Magnetic Conveyors of Chicago, Illinois.

The preferred precision shearing machine **210** includes dual shear dies or blades and corresponding platens (not shown) configured to simultaneously shear a portion of a joining edge from each of the blanks **130, 180**. Each of the dies and corresponding platens incorporate precision machined outside corner edges that are precisely aligned
10 with each other to impart a precision sheared edge on each of the blanks **130, 180**. Each die and each platen can also be fabricated to include a plurality of precision machined edges so that the dies and platens may be removed, reversed or rotated, and replaced when one of the edges becomes worn or out of tolerance. In this way, each die and platen may be reused more than once before the outside corner edges of each die and
15 platen must be remachined to restore the precision toleranced edge. Accordingly, each die and each platen can preferably include four precision machined edges.

Alternatively, at least two precision machined edges are achievable. Each edge is machined to impart a precision sheared edge to each blank **130, 180** so that when positioned into an abutting relationship, the sheared edges are substantially in uniform
20 contact with each other with a minimized gap therebetween of between approximately zero and 0.08 millimeters.

Preferably, between approximately 1 millimeter and approximately 10 millimeters are removed from the blanks. More preferably, between approximately 3 millimeters and approximately 5 millimeters are removed. Removal of this amount of
25 material assures that enough material is removed to eliminate possible edge defects in the raw stock material. Also, removal of at least this amount of material ensures that a clean shear results with a minimized amount of possible tolerance anomalies. In turn,

when the precision sheared edges are pressed together, the interface between the edges will be in substantially uniform contact with a correspondingly minimized gap therebetween. The use of dual shear dies and platens improves efficiency because shearing of both blanks **130, 180** is accomplished in a single step. However, a single die or blade is a suitable alternative for lower throughput applications. The preferred precision shearing machine **210** also automatically removes the sheared scrap from the machine before the blanks are transferred from the machine. For purposes of illustration only, and not for limitation, a suitable hydraulically operated, dual die, precision shearing machine is available from VIL of Chicago, Illinois.

After shearing the joining edges of the blanks, the conveyer assembly **200** or sub-conveyers **220, 225** release and transfer the blanks **130, 180** to an idle or queuing station **230** as can be seen with reference to FIGS. 5 and 9. The queuing station **230** operates to temporarily store the sheared blanks before welding. In an alternative embodiment, not shown, the idle station **230** can be replaced with at least one transfer robot having some or all of the capabilities of the first and second robots **120, 175**. By temporarily storing the sheared blanks **130, 180**, another set of blanks may be retrieved, aligned, and sheared by the precision shearing machine **210**.

LASER WELDER DISCLOSURE

As illustrated in FIGS. 5 and 10, a second conveyor **240** slidably repositions the blanks **130, 180** and moves them from the idle station **230** onto a welding bed **330** of a laser welding gantry **300**. To protect workers and other nearby equipment from injury due to reflected laser energy or plasma, sputter, and other debris, the laser welding gantry **300** is preferably enclosed. With reference also to FIGS. 5, 6a, and 6b, the gantry **300** incorporates a numerically controlled laser welder **350** configured to move across the gantry **300** and incorporating a laser weld head **355** and a laser weld inspection device **400**. Although in some applications a self-contained laser could be used, the

preferred embodiment of the present invention includes a laser weld head **355** that is powered by a remote laser unit **380** through a fiber optic cable **360** contained in a cable support tray **390**.

The laser welding gantry **300** incorporates an automated position adjustment and orientation system having a plurality of pusher elements **305** retractably arranged on the second conveyer **240** about the laser weld bed **330**. The pusher elements **305** are generally retracted down into the second conveyer **240** until the blanks are moved onto the laser weld bed **330**. Once in place, the locator assemblies **305** are actuated and rise up to releasably engage the exterior edges of the blanks **130, 180**, pushing the blanks into alignment so the precision sheared edges are registered substantially in parallel with each other and compressed into tight contact so that any gap between the precision sheared edges is minimized. Such locator assemblies can be similar in design to those employed by the precision conveyer **200**. Once the edges are registered and in contact, a clamping mechanism **310**, spanning substantially across the width of the gantry **300** above the welding bed **330**, is deployed so a plurality of clamp members **315** clamp down on the blanks **130, 180** to hold them in place against the bed **330** during welding.

The laser welder **350** is movably attached to the welding gantry **300** and is preferably numerically controlled by an appropriately programmed computer that can include any of the control computers **105**. The welder **350** is controlled to maintain a precise speed as it is moved across the gantry **300** during welding. The welder includes a laser weld head **355** that is connected by a fiber optic cable **360** to a remote laser power unit **380**. With reference to FIGS. 2, 3a, 3b, 6a, 6b, 6c, and 7, it can be understood that the weld head **355** is configured to focus and project a laser beam **370** incident to and focused upon the minimized gap **38** between the precision sheared edges blanks **130, 180** to irradiate the region around the precision sheared edges to weld them together by forming a weld bead seam **40, 40'**.

Many types of lasers are commercially available for various welding applications. For purposes of the present invention, however, it is preferable to use a single or dual cell (with corresponding single or dual optical fibers), solid, non-pulsed, continuous laser such as a neodymium doped, hard synthetic yttrium aluminum garnet laser (Nd-YAG). Preferably, the laser has output power rating of at least approximately 2.5 to approximately 3.0 kilowatts, and is preferably capable of generating a power output at the laser weld head **355** of at least approximately 2.3 to approximately 2.8 kilowatts, and more preferably a laser weld head **355** output of approximately 2.4 kilowatts. A suitable Nd-YAG laser includes the Model LW-8 Laser Blank Welder available from Lumonics, Inc. of Livonia, Michigan. Similarly powered gas and pulsed lasers can be used provided that they are capable of producing the specified power ranges. Although a single cell, single fiber laser is represented by the figures, a dual cell laser will be equally effective and will increase the throughput of the laser welder **350** accordingly.

A gas jet **385** is also part of the laser welder and the gas stream is directed in the forward direction following the direction of the travel of the laser beam **370** and onto the region of the edges being irradiated by the beam. The gas jet **385** produces a jet stream that reduces and ideally eliminates gaseous contamination of the weld and to minimize plasma shielding effects. The gas jet is preferably any of a number of inert gases including, for example, argon, helium, or nitrogen, and can also be directed against the underside of the weld region for additional protection of the weld. The forward direction of the resultant jet stream also "blows" the plasma cloud and other welding debris forward and away from the laser weld head **355** and its associated and proximate components including the inspection device discussed below.

With particular reference to FIGS. 6b and 6c, it can be seen that the laser beam **370** is focused to intersect the seam or interface **40** of the blanks and to irradiate their upper surface. The beam **370** projects at a compound angle to the vertical direction

perpendicular to the surface of the blanks **130**, **180**. The compound angle includes “leading” and “leaning” components. The vertical direction is represented by the “Y” direction of the reference coordinate system labeled “A” in FIGS. 6b and 6c. The “X” direction represents the forward direction of the incident laser beam **370** across the gantry **300** during welding. With reference to FIG. 6b, the laser beam **370** leading angle component is labeled “ θ ” (theta) and it is measured from the direction of the “Y” axis. Preferably, the leading angle, θ , is between approximately 5 degrees and 15 degrees, more preferably between 7 and 12 degrees, and is most preferably approximately 10 degrees.

10 The leading angle serves several important functions. First, the leading angle, θ , prevents reflection of incident laser energy back into the laser weld head **355** and, in turn, into the laser unit. Next, leading angle θ allows the laser weld head **355** to lag the point on the surface where welding occurs. This protects the weld head **355** from contacting the plasma cloud and weld spatter and debris during welding. Third,

15 leading angle θ changes the shape of the laser beam spot that irradiates the weld seam region. Ordinarily, the weld beam spot would be a circle if the beam was perpendicular to the work piece surface. However, a circular weld spot creates a very high energy density that creates welding problems that are difficult to control by adjusting the speed of travel of the laser beam **370**. Thus, it has been found that by

20 imparting an angle from the perpendicular to the incident direction of the laser beam **370**, the laser beam spot will achieve an elliptical shape on the irradiated surface with the major elliptical axis substantially parallel to the direction of travel of the laser beam spot or the X direction of FIG. 6b. In turn, the elliptical shape reduces the energy density on the irradiated surface by spreading it over a larger area. The

25 reduced effective energy density of the laser beam spot allows better control of the welding process by variance, for example, of a single welding parameter such as the speed of travel of the laser beam spot across the weld seam. Such techniques are

described in a number of U.S. Patents including, for example, U.S. Patent No. 5,595,670 to Mumbo-Caristan which is hereby incorporated by reference in its entirety.

With reference to FIG. 6c, the reference coordinate system **A** describes the same Y direction as depicted in FIG. 6b. The “Z” direction points in the lateral direction of the blanks **130, 180** (the Z direction is directed up and out of the plane of FIG. 6b). In FIG. 6c, the X direction is directed up and out of the plane of the view. The leaning angle component of the compound laser beam angle is labeled “ γ ” (gamma). Preferably, angle γ is between approximately 1 and approximately 10 degrees, more preferably between 3 and 7 degrees, and is most preferably approximately 5 degrees. The leaning angle γ serves to further impart an elliptical shape to the laser beam spot with the major elliptical axis due to angle γ substantially perpendicular to the direction of beam spot travel and the X direction of FIG. 6b. When welding blanks of substantially similar thickness, the beam spot is focused and positioned to irradiate substantially equal regions of the blanks on both sides of the weld seam. However, when welding blanks of substantially dissimilar thickness, the leaning angle γ is configured to precisely position approximately between 15 percent and 30 percent, and more preferably approximately 25 percent of the cross-sectional area of the elliptical laser beam spot upon the protruding vertical face of the thicker blank (see reference numeral **35** of FIG. 2). It will be understood that the remaining portion of the beam spot will irradiate the thinner blank.

With these desired leading and leaning angles, the preferred speed of travel of the laser beam spot across the blanks, as controlled by the speed of the laser welder **350**, that creates the optimum weld bead seam is preferably between approximately 4 and approximately 10 meters per minute, and more preferably approximately 7 meters per minute. These welding parameters have been used to create a welded work piece

wherein the welded seam is at least 30 inches in length and has a tensile, pull strength exceeding approximately 9,000 pounds.

These angles and speeds were empirically derived and are based upon extensive trial and error experimentation because no data existed as to how the Nd-
5 YAG laser would perform in welding dissimilar thickness materials at speeds greater than that possible with the prior art gas, pulsed, and CO₂ lasers. The preceding parameters have thus been discovered to significantly minimize laser weld anomalies, such as burn-through, cracking, and pores.

10 INSPECTION SYSTEM DISCLOSURE

The laser welding system **100** also preferably incorporates a laser weld inspection and quality control device **400**, as represented in FIGS. 6a and 6b, which is mounted to cooperate with the laser welder assembly **350** of the gantry **300**. In
15 Figures 6a and 6b, the laser welding inspection device **400** is shown mounted to the gantry **300** to move along with the laser welder **350** during the welding operation.

As the laser weld head **355** projects the laser beam **370** to irradiate the seam **40** between the work pieces **130**, **180**, a molten weld pool **402** is generated at the focal point **404** of the laser beam **370**. As the laser beam **370** and weld pool **402** traverse the seam **40**, a weld bead is created. The laser weld inspection device **400** utilizes an
20 image capturing device, namely a visual sensor **410**, such as a CCD (Charge Coupled Device), or a high shutter speed video camera. For purposes of illustration, and not limitation, an example of a visual sensor **410** is the model MVS-5 camera from Modular Vision Systems of Montreal, Canada. Preferably, the visual sensor **410** is mounted rearward of the laser weld head **355** using a structure such as a camera
25 mounting bracket **420**, although in an alternative embodiment of the present invention, the visual sensor may be self-propelled and have its own support structure. The visual sensor **410** is focused on the welding path, at a predetermined distance **425**

behind the laser's current focal point **404**. The distance **425** between the focal point of the laser **404** and the focal point of the visual sensor **430**, is selected so that the images captured by the visual sensor **410** will reflect a fully solidified weld bead. In the preferred embodiment of the invention, the distance **425** is between approximately 5 75 millimeters and approximately 200 millimeters, and more preferably between approximately 100 millimeters and approximately 200 millimeters. Even more preferably, the distance **425** is about 150 millimeters. The visual sensor **410** is also mounted at a specific angle " ϕ " (phi), preferably between approximately 5 and approximately 10 degrees toward the direction of travel, labeled as the X direction in 10 the figures. In the preferred embodiment of the invention, the visual sensor **410** has a field of view of approximately 5 millimeters by approximately 5 millimeters, although the field of view may be altered based on the size of the weld to be inspected.

The visual sensor **410** is configured to capture images of the weld bead at predetermined time intervals based on considerations such as the linear velocity of the 15 laser weld head **355** and the particular features of the weld bead to be inspected. In one preferred embodiment of the present invention, the visual sensor **410** captures approximately one image per every 4 millimeters of travel while moving at a linear velocity of approximately 6 meters per minute.

A representative cross-sectional view of a weld to be inspected is shown in 20 Figure **3a**. The blanks **130**, **180** are selected to be of dissimilar thickness and are fabricated from a material such as, for example, steel sheet metal blanks. The blanks, are joined through a seam whose length is normal to the surface of the paper. The blanks **130**, **180** are joined by welding using the laser welder **350**. The intense heat of the laser beam **370** creates a melt zone **440** as it contacts the seam **40** between the 25 blanks. As this melt zone cools, the weld bead **445**, **450** forms on both the top and bottom surfaces of the welded work piece.

Figure 7 describes a representative comparison procedure that is included in the system software of the present invention. As the laser weld head **355** follows the seam, the visual sensor **410** trails directly behind, viewing an image of the fully formed weld bead **445** at predefined intervals. The images captured by the visual sensor are electronically communicated to a selected computer, such as one of the control computers **105**, that incorporates an image processor having image processing hardware or software, or both. The image processor first analyzes the image to determine the edges of the weld bead. The image processor then measures the image in several preselected dimensional areas, which will be described in detail below. The image is first measured for bead width **A** and top mismatch **B**, (Figure 3a). After bead width **A** and top mismatch **B** are calculated, the image processor measures the image for top concavity **C** and top convexity **D**. The selected computer, or any of the other control computers **105**, or both, also include a distinction device that incorporates an image coprocessor having hardware or software components, or both, and in electronic communication with the image processor. The distinction device cooperates with the image processor to compare the values of bead width **A**, top mismatch **B**, top concavity **C**, and top convexity **D** with corresponding reference images or values, or both, that represent the values of acceptable weld parameters and dimensions.

Once the comparison of each selected dimensional area is complete, the distinction device determines the quality of the weld and whether the welded work piece should be accepted or rejected. If it is determined that the selected characteristics of the weld bead image are within the limits of the predetermined, acceptable weld parameters and dimensions, a signal is generated classifying the weld as acceptable. If it is determined that the image is outside the predetermined, acceptable weld parameters and dimensions, a signal is generated classifying the weld as rejected. The signal may also be used to initiate the next appropriate machine

process step to be performed on the welded part. For example, the signal may be sent to the removal station **510** described below and the articulating arm robot **520** for removal to an accepted work piece skid **530** or a rejected work piece skid **540**.

As described in the procedure of Figure 7, in a preferred embodiment of the invention, the captured images and the reference images are analogized in four specific dimensional areas Referring again to Figure **3a**, these dimensional areas are depicted as bead width **A**, top mismatch **B**, top concavity **C**, and top convexity **D**.

Bead width **A** is the distance between the two limit points defining the edges of the weld bead **445**, measured along an axis perpendicular to the length of the seam on the top surface of the work pieces **130**, **180**.

As shown in Figure **3a**, the work pieces **130**, **180** are preferably aligned to have each of their bottom surfaces in the same plane. If the work pieces are of substantially dissimilar thickness, then top mismatch **B** will exist as the difference in height between the top surface of one blank **130**, and the top surface of the other blank **180**. Although top mismatch **B** is depicted in the preferred embodiment of Figure **3a**, the work pieces may also be of substantially equivalent thickness, with both their top and bottom surfaces lying in the same plane. In this case, mismatch between the adjoining work piece surfaces would be negligible.

The images are also compared for top concavity **C**, which is the maximum depth to which the weld bead **445** has sunken, measured from the top surface of one of the blanks or the thinner blank **130**, if they are of dissimilar thickness. The reference surface for purposes of the top concavity **C** measurement may change based upon the alignment and thickness of the work piece blanks **130**, **180**.

The fourth dimensional area selected for purposes of comparison is top convexity **D**. Top convexity **D** is the maximum height of the weld bead **445**, measured from the top surface of the blanks or the top surface of the thicker blank **180** if blanks of dissimilar thickness are used. Like top concavity **C**, the reference surface

for purposes of the top convexity **D** measurement may change based upon the alignment and thickness of the work pieces **130, 180**.

In an embodiment denoted in Figure **3a**, all images of the weld bead **445** are generated by the visual sensor **410** from above the work pieces. However, it should
5 be understood that it is also possible in another embodiment of the invention, to utilize an additional visual sensor for viewing the portion of the weld bead **450** formed along the bottom surface of the work pieces **130, 180**. Additional dimensional comparison areas may also be included in the weld bead analysis. These additional comparison areas, as denoted in Figure **3a**, may include root width **E**, bottom
10 concavity **F**, and bottom convexity **G**. Further, an additional visual sensor may be incorporated for use in a dual-cell laser configuration of the present invention so that more than one segment of the weld bead may be inspected in cooperation with each of the dual laser weld heads. Root width **E** is the distance between the two limit points defining the edges of the weld bead **450**, taken along an axis perpendicular to the
15 length of the seam on the bottom surface of the work piece.

As illustrated in Figure **3b**, the blanks **130, 180** may be aligned so neither their respective top nor bottom surfaces lie in the same plane. In this circumstance, bottom mismatch **H** will occur as the difference in height between the bottom surface of one blank, and the bottom surface of the other blank. Bottom mismatch may also be
20 selected as a dimensional comparison area.

Referring again to Figure **3a**, bottom concavity **F** is shown as the maximum depth of the weld bead **450** below the bottom surface of the work pieces **130, 180**. The maximum height of the weld bead **450** as measured from the bottom surface of the work pieces may also be checked. This measurement is defined as bottom
25 convexity **G**.

The selected dimensional comparison steps are described above in an exemplary sequence representative of the preferred embodiment of the present

invention. However, any sequence of the above steps is equally satisfactory and the preceding description is presented for purposes of illustration but not limitation.

Moreover, the exemplary procedure setting forth the comparison and analysis steps is not limited to any particular number or combination of dimensional areas described
5 above. Additional inspection steps may be added, and existing steps may be removed without departing from the scope of the invention.

New reference images may be created that adopt existing dimensional comparison areas, create new areas, or utilize combinations of both. A reference image may have adjustable tolerance zones which can be set for each area of
10 dimensional comparison. In this manner, distinct reference images can exist for use under particular conditions.

A visual display monitor, such as is well known, may be connected to the image processing board or any of the control computers **105**, or both, to display the weld bead image captured by the visual sensor **410**. An additional monitor may be
15 connected to display, for example, the reference image or dimensional comparison area tolerance zones using graphic overlays of the predetermined parameters. The system may also employ a communication board to send signals to other equipment, such as, for example, any of the control computers **105**, as dictated by the results of the weld bead analysis and for purposes of archiving captured images for future
20 analyses and comparisons.

In the present invention, a clear image of the weld bead is critical. Therefore, it is necessary to safeguard the visual sensor **410** from contamination. Although the visual sensor **410** is maintained at a preselected distance **425** (Figure 6b) rearward from the laser weld head **355**, the visual sensor **410** is sufficiently proximate the weld
25 pool **402** to be affected by plasma, weld spatter, and other debris. Plasma, smoke and particles of liquid metal (spatter) that are emitted from the weld pool **402** during the welding process, may migrate to, and damage the visual sensor **410**. Therefore, a

means for preventing such damage is preferably utilized. In one preferred embodiment of the invention, a compressed air stream **485** is employed to pass across, and deflect any errant debris away from the visual sensor. Other methods such as the gas jet **385** used with the laser weld head **355**, filters or vacuum means, for example, 5 may be applied to perform an equivalent function.

With reference to Figures 5 and 11, an exit conveyer station **500** is depicted as part of the automated welding system **100**. The station **500** includes an exit conveyer **505** that cooperates with the second conveyor **240** to transfer the welded work piece from the laser welding bed **330** to a removal station **510**. The removal station can 10 include another articulating arm robot **520** that is similar in design to and can include any or all of the features of the robots **120**, **175** already described. Depending on whether the welded work piece has been accepted or rejected during the inspection of the laser weld, the removal robot **520** will remove the work piece from the exit conveyer **505** and put it onto one of a plurality of accepted skids **530** or on a reject skid **540**. 15 Since the quantity of rejected parts is likely to be very small and since it may be desirable to immediately remove and inspect any rejected work pieces, it may not be necessary to put the rejected pieces on a skid. In such a case, **540** may be replaced by a gravity roller conveyor or other means for removing the work piece from the automated welding system **100**. For worker safety, the exit conveyer station **500** is configured 20 similar to the feeder station **110** and is surrounded with a safety fence or partition **545** configured with light curtain assemblies or specially adapted doors, or both, to detect intrusions into the work area of the exit station **500**. Additionally, the accepted skids or the rejected skids, or both, are surrounded by light curtains **555** having the same capabilities described with respect to the feeder station **110**.

INDUSTRIAL APPLICABILITY

From the foregoing, it can be appreciated that the present invention fulfills a real but heretofore unmet need for a structurally improved welded work piece that is less expensive to manufacture, includes fewer parts, and is lighter in weight. The present invention also fulfills the need for a method for manufacturing such a welded work piece that overcomes the undesirable features, deficiencies, and shortcomings of presently available welded work pieces and methods for their manufacture. The invention fulfills these needs of the automotive industry through the novel design of a welding gantry that comprises a laser beam aimed at a compound angle, to irradiate the pieces to be welded. The welding gantry may also comprise an inspection device that travels with the laser welder during the welding operation. The inspection device captures images of the weld bead and transmits those images to an image processing board. Various weld bead parameters are then compared to reference values by a distinction device. If the weld bead is within tolerance on all parameters, the work piece is considered accepted and moved to an accepted work piece skid. If the weld bead is not within tolerance on all parameters, the work piece is considered rejected and moved to a rejected work piece skid. The welding gantry may also comprise protection means for the welding head and/or the inspection device, such as gas streams.

The invention also fulfills the needs of the automotive industry for improved work pieces through the use of an automated system that comprises robots for the transport of sheet metal blanks to a conveyor system, a conveyor system, a precision shearing device, a laser welding gantry, and robots for the transport of welded work pieces from the conveyor.

Each of the described embodiments and variations, as well as other obvious yet undescribed embodiments of the invention, and equivalents thereof, may be used either alone or in combination with each of the other embodiments. While particular preferred embodiments of the invention have been illustrated and described, various modifications

and combinations can be made without departing from the spirit and scope of the invention, and all such modifications, combinations, and equivalents are intended to be covered and claimed.

WHAT IS CLAIMED IS:

1. A welded work piece comprising:
 - a first blank of a metallic sheet stock with a first thickness and having at least one first precision sheared edge;
 - a second blank of metallic sheet stock with a second thickness different than the first thickness and having at least one second precision sheared edge;
 - a laser welded seam permanently joining the respective first and second precision sheared edges;wherein the respective first and second precision sheared edges of the respective first and second blanks are aligned to form a minimized gap therebetween before being welded.
2. The welded work piece according to Claim 1 wherein the minimized gap is between approximately zero and 0.08 millimeters.
3. The welded work piece according to Claim 1 wherein the minimized gap is approximately 0.04 millimeters.
4. The welded work piece according to Claim 1 wherein one blank thickness is between approximately 0.50 millimeters and approximately 0.75 millimeters and the other blank thickness is between approximately 1.25 millimeters and approximately 1.50 millimeters.
5. The welded work piece according to Claim 1 wherein one blank thickness is approximately 0.7 millimeters and the other blank thickness is approximately 1.4 millimeters.
6. The welded work piece according to Claim 1 wherein the first and second blanks are formed from a steel material.
7. The welded work piece according to Claim 1 wherein the welded seam is at least approximately 30 inches and has a tensile, pull strength exceeding approximately 9,000 pounds.

8. The welded work piece according to Claim 1 wherein:

the laser welded seam is manufactured with a continuous wave Nd-YAG laser, the angle of the laser beam to the minimized gap being compound and having a leading angle θ of between 5 and 15 degrees and a leaning angle γ of between 1 and 10 degrees;

the laser beam is focused substantially into an elliptical shaped spot about the gap formed between the respective joining edges; and

approximately 75 percent of the cross-sectional area of the elliptical shaped spot of the laser beam is incident upon one of the blanks.

9. A welded work piece for use in manufacturing an automotive vehicle, comprising:

first and second sheet metal blanks each formed with at least one precision sheared edge and of dissimilar thickness and wherein the blanks form a minimized gap when the respective at least one precision sheared edges are positioned in an abutting relationship; and

a continuous wave laser butt welded seam fixedly joining the blanks together along at least one of the respective precision sheared edges.

10. The welded work piece according to Claim 9 wherein the sheet metal blanks are formed from a steel material.

11. The welded work piece according to Claim 9 wherein:

the seam is welded with a non-pulsed, continuous Nd-YAG laser, the angle of the laser beam to the minimized gap being compound and having a leading angle θ of between 5 and 15 degrees and a leaning angle γ of between 1 and 10 degrees;

the laser beam is focused substantially into an ellipse shaped spot about the gap formed between the respective joining edges; and

approximately 75 percent of the cross-sectional area of the ellipse shaped spot of the laser beam is incident upon one of the blanks.

12. The welded work piece according to Claim 9 wherein at least one respective surface of each of the first and second blanks are coplanar.

13. The welded work piece according to Claim 9 wherein the flat exterior surfaces of the first and second blanks are not coplanar.

14. A method for manufacturing a welded work piece comprising the steps of:

selecting a first blank of a metallic sheet stock with a first thickness and having at least one first precision sheared edge;

selecting a second blank formed from a metallic sheet stock material of a second thickness different than the first thickness and having at least one second precision sheared edge;

laser welding a seam to permanently join the respective first and second precision sheared edges; and

wherein the respective first and second precision sheared edges are formed in the respective first and second blanks to form a minimized gap therebetween before being welded.

15. A system for manufacturing a welded work piece, comprising:

a precision shear device configured with at least one upper stamping die that cooperates with at least one lower stamping platen to precisely shear at least one of the respective joining edges of a plurality of sheet metal blanks;

a welding gantry spaced apart from the precision shear device having a laser weld bed and connected to the precision shear device through a conveyor, the conveyor being configured to slidably receive the sheared blanks from the shear device and to move them onto the laser weld bed, and including a clamping and positioning assembly operative to releasably register and press the respective sheared

edges of the blanks flat against the weld bed and tightly together in an abutting relationship to form a minimized gap; and

a laser welder movably attached to the welding gantry and having a weld head powered by a remote laser power unit to project a laser beam incident to and focused upon the gap for welding the blanks along the gap to form a weld bead seam and wherein the laser beam is at a compound angle to the minimized gap.

16. A system for manufacturing a welded work piece, comprising:

a welding gantry configured with a conveyor having a laser weld bed and adapted to slidably receive a plurality of sheet metal blanks each formed with at least one respective precision sheared joining edge, the conveyer being configured to move the blanks onto the laser weld bed, and including a clamping and positioning assembly operative to releasably register and press the respective joining edges of the blanks flat against the weld bed and tightly together in an abutting relationship to form a minimized gap;

a laser welder movably attached to the welding gantry and having a weld head powered by a remote laser power unit to project a laser beam incident to and focused upon the gap at a compound angle for welding the blanks along the gap to form a weld bead seam; and

a laser weld inspection device slidably coupled to the welding gantry and operative to inspect the weld bead.

17. A system for manufacturing a welded work piece, comprising:

a precision shear device configured with at least one upper stamping die that cooperates with at least one lower stamping platen to precisely shear a respective joining edge of each of a plurality of sheet metal blanks;

a welding gantry spaced apart from the precision shear device and configured with a conveyor having a laser weld bed and being configured to slidably receive the sheared blanks from the precision shear device and to move them onto the

laser weld bed, and including a clamping and positioning assembly operative to releasably register and press the respective joining edges of the blanks flat against the weld bed and tightly together in an abutting relationship to form a minimized gap;

a laser welder movably attached to the welding gantry and having a weld head powered by a remote laser power unit to project a laser beam incident to and focused upon the gap at a compound angle for welding the blanks along the gap to form a weld bead seam; and

a laser weld inspection device slidably coupled to the welding gantry and operative to inspect the weld bead.

18. The system for manufacturing a welded work piece according to Claim 15 wherein the laser welder includes a dual cell laser assembly.

19. The system for manufacturing a welded work piece according to Claim 15 wherein the laser welder comprises a Nd-YAG laser.

20. The system for manufacturing a welded work piece according to Claim 15 wherein the laser beam is focused substantially into an elliptical shaped spot about the gap formed between the respective joining edges.

21. The system for manufacturing a welded work piece according to Claim 20 wherein approximately 75 percent of the cross-sectional area of the elliptical shaped spot of the laser beam is incident upon one of the blanks.

22. The system for manufacturing a welded work piece according to Claim 15 wherein at least two of the plurality of blanks are of substantially dissimilar thickness.

23. The system for manufacturing a welded work piece according to Claim 15 wherein at least two of the plurality of blanks are of substantially similar thickness.

24. The system for manufacturing a welded work piece according to Claim 15, 16, or 17 wherein the minimized gap is between approximately zero and 0.08 millimeters.

25. The system for manufacturing a welded work piece according to Claim 15, 16, or 17 wherein the minimized gap is approximately 0.04 millimeters.

26. The system for manufacturing a welded work piece according to Claim 22 or 23 wherein the laser welder is adjusted so the laser beam has an angle of incidence relative to the gap that is offset from a vertical direction substantially normal to the blanks and that is between approximately 5 and approximately 15 degrees in a substantially leading direction.

27. The system for manufacturing a welded work piece according to Claim 16 wherein:

the compound angle has a leading angle θ of between 5 and 15 degrees and a leaning angle γ of between 1 and 10 degrees;

the laser beam is focused substantially into an elliptical shaped spot about the gap formed between the respective joining edges; and

approximately 75 percent of the cross-sectional area of the elliptical shaped spot of the laser beam is incident upon one of the blanks.

28. The system for manufacturing a welded work piece according to Claim 22 wherein the laser welder is adjusted so the laser beam has an angle of incidence relative to the gap that is offset from a vertical direction substantially normal to the blanks and the gap is between approximately 1 and approximately 10 degrees in a direction substantially leaning away from the thicker work piece.

29. The system for manufacturing a welded work piece according to Claim 27 wherein the laser beam is moved along the gap to form the weld bead seam at a speed of between approximately 4 and approximately 10 meters per minute.

30. The laser welder according to Claim 29 wherein the laser beam is moved along the gap to form the weld bead seam at a speed of approximately 7 meters per minute.

31. A system for manufacturing a welded work piece, comprising:

at least one articulating arm feeder robot configured to retrieve at least one blank from at least one of a plurality of feeder skids of palletized sheet metal blanks, each blank formed with at least one joining edge, and adapted to transport the blank to a load position on a magnetic conveyor;

the magnetic conveyor is adapted to receive from the feeder robot at least two of the plurality of blanks and to precisely position them on a conveyor bed, the blanks are proximally pre-positioned so each of the respective joining edges are substantially parallel, the magnetic conveyor is further configured to releasably restrain the positioned blanks into place and to move them from the load position to a shear position;

a precision shear device is positioned about the shearing position of the magnetic conveyer and configured with at least one upper stamping die that cooperates with at least one lower stamping platen to precisely shear at least one of the respective joining edges;

a welding gantry is spaced apart from the precision shear device and configured with a second conveyor having a laser weld bed and connected to the magnetic conveyer with an idle station therebetween, the second conveyer being configured to slidably receive the sheared blanks from the idle station and to move them onto the laser weld bed, and including a clamping and positioning assembly operative to releasably register and press the respective joining edges of the blanks flat against the weld bed and tightly together in an abutting relationship to form a minimized gap;

a laser welder movably attached to the welding gantry and having a weld head powered by a remote laser power unit to project a laser beam incident to and focused upon the gap for welding the blanks along the gap to form a weld bead seam;

a laser weld inspection device slidably coupled to the welding gantry and operative to inspect the weld bead;

an exit conveyor coupled to the second conveyor and configured to remove the welded work piece from the laser weld bed; and

an articulating arm exit robot configured to move the work piece from the exit conveyor to an exit station selected from the group of one of a plurality of accepted work piece skids or a rejected work piece skid.

32. The system for manufacturing a welded work piece according to Claim 31, further comprising:

a light curtain partition including at least one light curtain sensor skid removal sensor proximate to at least one of the plurality of feeder skids and operative to generate a skid removal signal upon detecting removal.

33. A method for manufacturing a welded work piece, comprising the steps of:

shearing a precision edge on a respective joining edge of a plurality of sheet metal blanks using a precision shear device configured with at least one upper stamping die that cooperates with at least one lower stamping platen to perform the shearing operation;

moving the plurality of precision sheared blanks together on a conveyor from the precision shear device to a laser weld bed of a welding gantry;

precisely locating the blanks to register the precision sheared edges in a compressed, abutting relationship;

clamping the respective joining edges of the blanks flat against the weld bed and tightly together in an abutting relationship to form a minimized gap; and

laser welding the edges to form a beaded seam and to permanently join the blanks together.

34. A method for manufacturing a welded work piece, comprising the steps of:

- selecting a plurality of blanks each formed with at least one precision sheared edge;
- precisely locating the blanks on a laser weld bed of a welding gantry to register the precision sheared edges in a compressed, abutting relationship;
- clamping the respective joining edges of the blanks flat against the weld bed and tightly together in an abutting relationship to form a minimized gap between the edges;
- laser welding the edges to form a beaded seam and to permanently join the blanks together; and
- inspecting the weld bead with a laser weld inspection device slidably coupled to the welding gantry.

35. A laser welder for welding a plurality of work pieces, comprising:

- a laser weld head configured to movably project a laser beam onto a minimized gap formed between a plurality of adjacent, substantially flat work pieces formed with respective precision sheared edges and wherein the edges are positioned in an abutting relationship and the laser weld head is operative to weld the edges by forming a weld bead seam between the edges; and

- wherein the laser beam is incident on the gap with a compound angle, measured relative to the vertical direction substantially normal to the work pieces, that includes a leading angle component substantially in the direction of movement of the laser weld beam and a leaning component substantially in the direction normal to the gap and leaning towards one of the blanks away from the vertical direction.

36. The laser welder according to Claim 35 wherein the blanks are of substantially the same thickness.

37. The laser welder according to Claim 35 wherein the blanks are of substantially dissimilar thickness.

38. The laser welder according to Claim 35 wherein the leading angle component is between approximately 5 degrees and approximately 15 degrees.

39. The laser welder according to Claim 35 wherein the leading angle component is approximately 10 degrees.

40. The laser welder according to Claim 35 wherein the leaning angle component is between approximately 3 degrees and approximately 7 degrees.

41. The laser welder according to Claim 35 wherein the leaning angle component is approximately 5 degrees.

42. The laser welder according to Claim 35 wherein the laser beam is focused upon the blanks to have approximately 75% of its cross-sectional area incident upon one side of the gap and on one of the blanks.

43. The laser welder according to Claim 35 wherein the minimized gap is between approximately zero and 0.08 millimeters.

44. The laser welder according to Claim 35 wherein the minimized gap is approximately 0.04 millimeters.

45. The laser welder according to Claim 35 wherein the laser beam is energized by a non-pulsed, continuous laser.

46. The laser welder according to Claim 45 wherein the laser beam is energized by a Nd-YAG laser.

47. A multi-celled laser welder, comprising:
a plurality of laser weld heads each configured to movably project a laser beam onto a plurality of minimized gaps formed between a plurality of adjacent, flat work pieces formed with respective precision sheared edges, wherein the edges are positioned in an abutting relationship and the laser weld heads are operative to weld the edges by forming a weld bead seam between the edges; and

wherein the laser beams are incident on the gaps with a compound angle, measured relative to the vertical direction substantially normal to the work pieces, that includes a leading angle component substantially in the direction of movement of the laser beams and a leaning component substantially in the direction normal to the gaps and leaning towards one of the blanks away from the vertical direction.

48. The laser welder according to Claim 35 or 47 wherein the laser beam is moved along the gap to form the weld bead seam at a speed of between approximately 4 and approximately 10 meters per minute.

49. The laser welder according to Claim 35 or 47 wherein the laser beam is moved along the gap to form the weld bead seam at a speed of approximately 7 meters per minute.

50. A laser welding inspection system comprising:
a laser welding device;
an image capturing device for capturing the image of a laser weld bead;
an image processing device in electronic communication with the image capturing device, for measuring at least one dimension of the laser weld bead image captured by the image capturing device;
a distinction device in electronic communication with the image processing device, for comparing the value of the at least one dimension of the laser weld bead image measured by the image processing device with a reference value, to determine the quality of the laser weld.

51. The system of Claim 50 wherein the image capturing device is attached to and moves with the laser welding device.

52. The system of Claim 50 wherein the image capturing device is movable independently from the laser welding device.

53. The system of Claim 50 wherein the image capturing device is a video camera.

54. The system of Claim 50 wherein the at least one dimension of the laser weld bead is selected from the group consisting of bead width, top mismatch, top concavity, top convexity, root width, bottom mismatch, bottom concavity, and bottom convexity.

55. The system of Claim 54 wherein the dimensions of bead width, top mismatch, top concavity, top convexity, root width, bottom mismatch, bottom concavity, bottom convexity and any combination thereof are measured by the image processing device.

56. The system of Claim 55 wherein any of the combinations measured by the image processing device are compared by the distinction device to a reference value corresponding to any of the measured dimensions.

57. The system of Claim 50 further comprising a welded work piece to be inspected after welding.

58. The system of Claim 57 wherein the work piece is welded together from blanks of approximately equal thickness.

59. The system of Claim 57 wherein the work piece is welded together from blanks of substantially dissimilar thickness.

60. The system of Claim 59 wherein the blanks are aligned so the bottom surface of each respective blank lies are coplanar after welding.

61. The system of Claim 59 wherein the blanks are aligned so the top surface of each respective blank lies are coplanar after welding.

62. The system of Claim 59 wherein the blanks are aligned so neither the respective top surfaces nor the respective bottom surfaces of the blanks are coplanar after welding.

63. The system of Claim 50 further comprising a second image capturing device, the image capturing device oriented to capture a weld bead image on the bottom surface of a welded work piece.

64. A method of inspecting a laser weld, the method comprising:
capturing an image of a laser weld bead;
measuring at least one dimension of the laser weld bead image; and
comparing the value of the at least one dimension of the laser weld bead image with a reference value to determine the quality of the laser weld.

65. The method of Claim 64 wherein the at least one dimension of the laser weld bead is selected from the group consisting of bead width, top mismatch, top concavity, top convexity, root width, bottom mismatch, bottom concavity, and bottom convexity.

66. The method of Claim 64 wherein the dimensions of bead width, top mismatch, top concavity, top convexity, root width, bottom mismatch, bottom concavity, bottom convexity and any combination thereof are measured by the image processing device.

67. The method of Claim 66 wherein the combinations measured by the image processing device are compared by the distinction device to reference values corresponding to the measured dimensions.

68. The method of Claim 64 further comprising:
generating a signal based upon the quality of the laser weld as determined by the distinction device; and
outputting the signal to identify the quality of the welded work piece.

69. The method of Claim 68 additionally comprising the steps of:
removing the welded work piece from the laser welder; and
depositing the work piece in a selected location based upon the quality of the laser weld.

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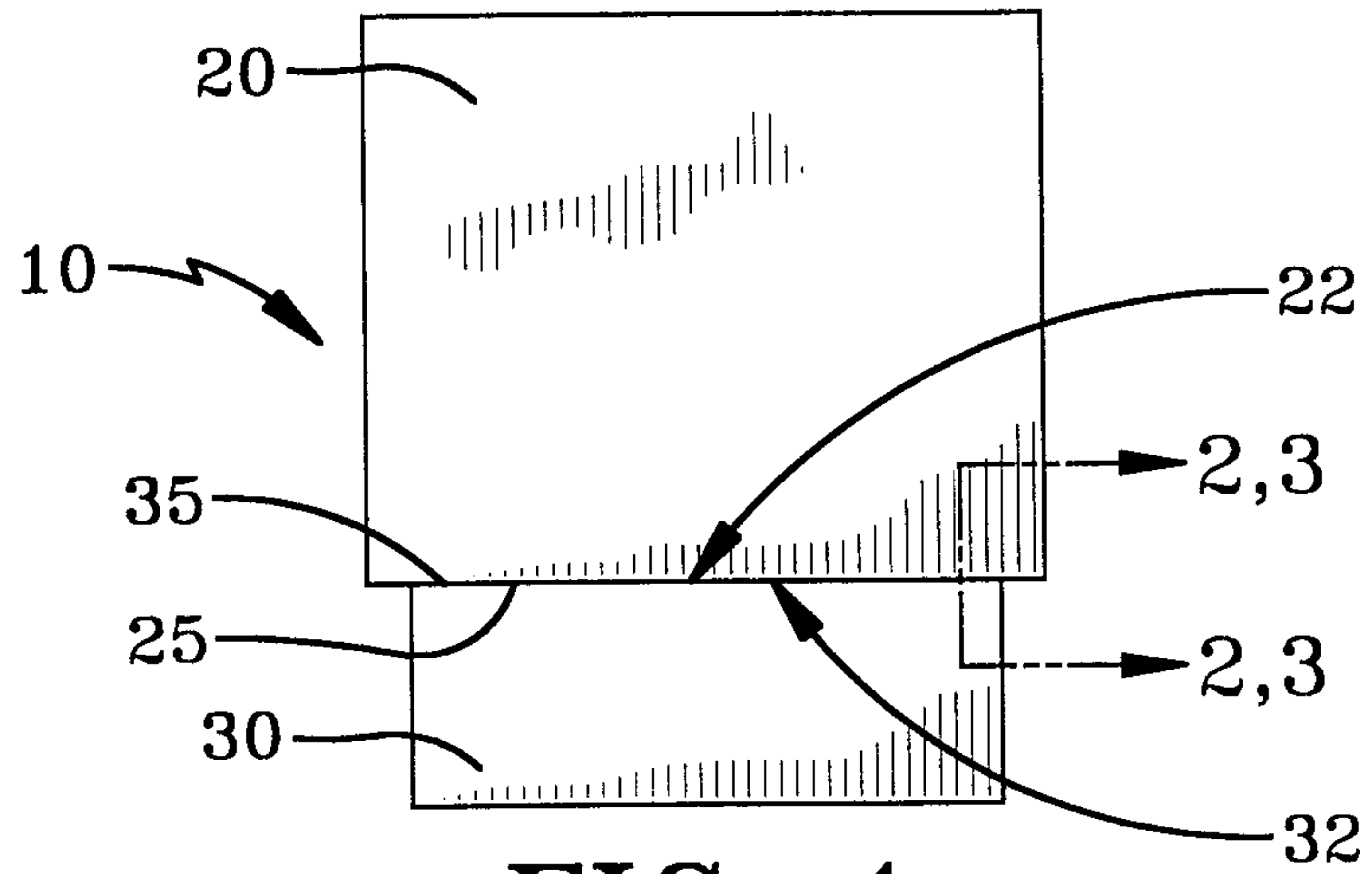


FIG-1

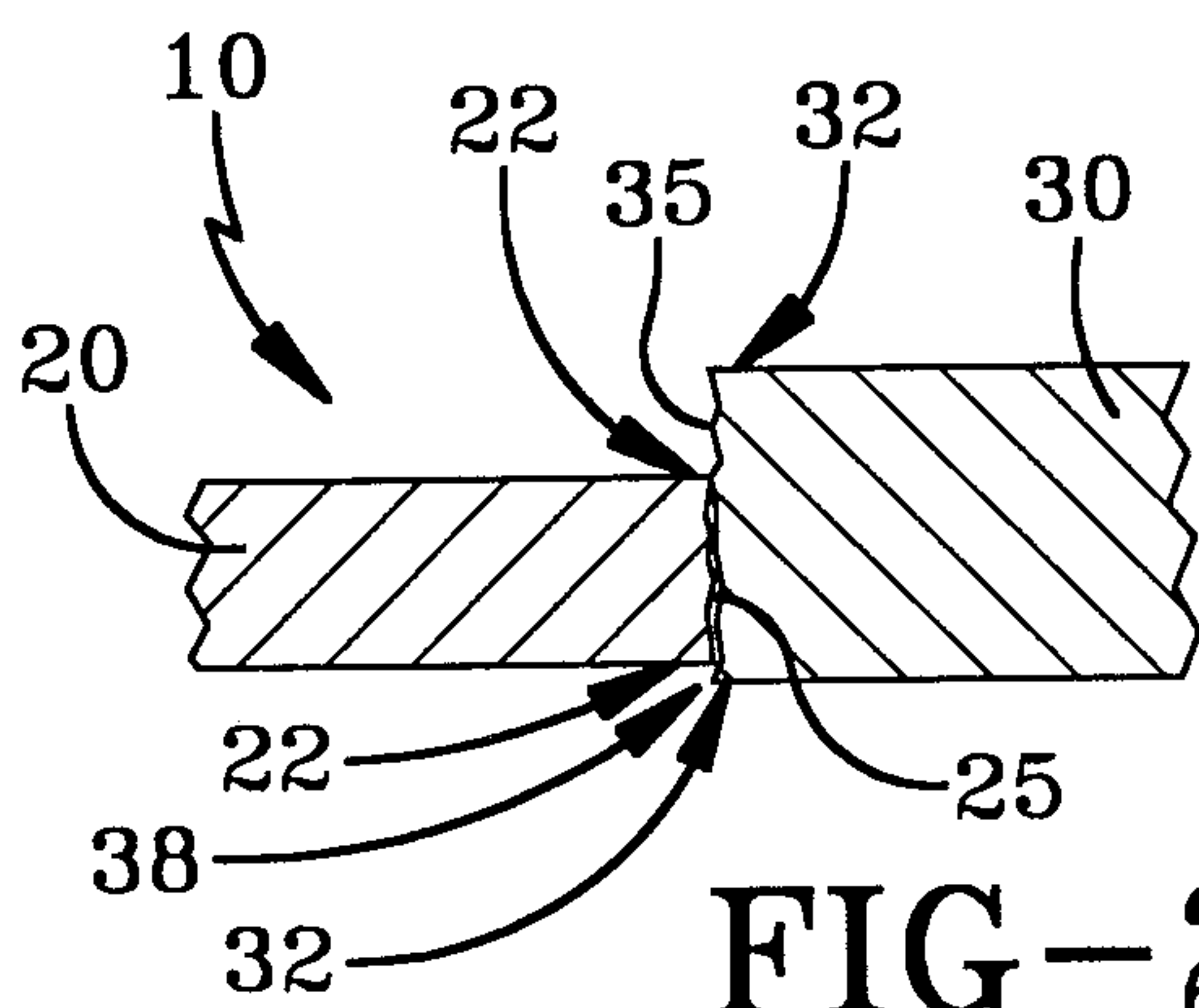


FIG-2

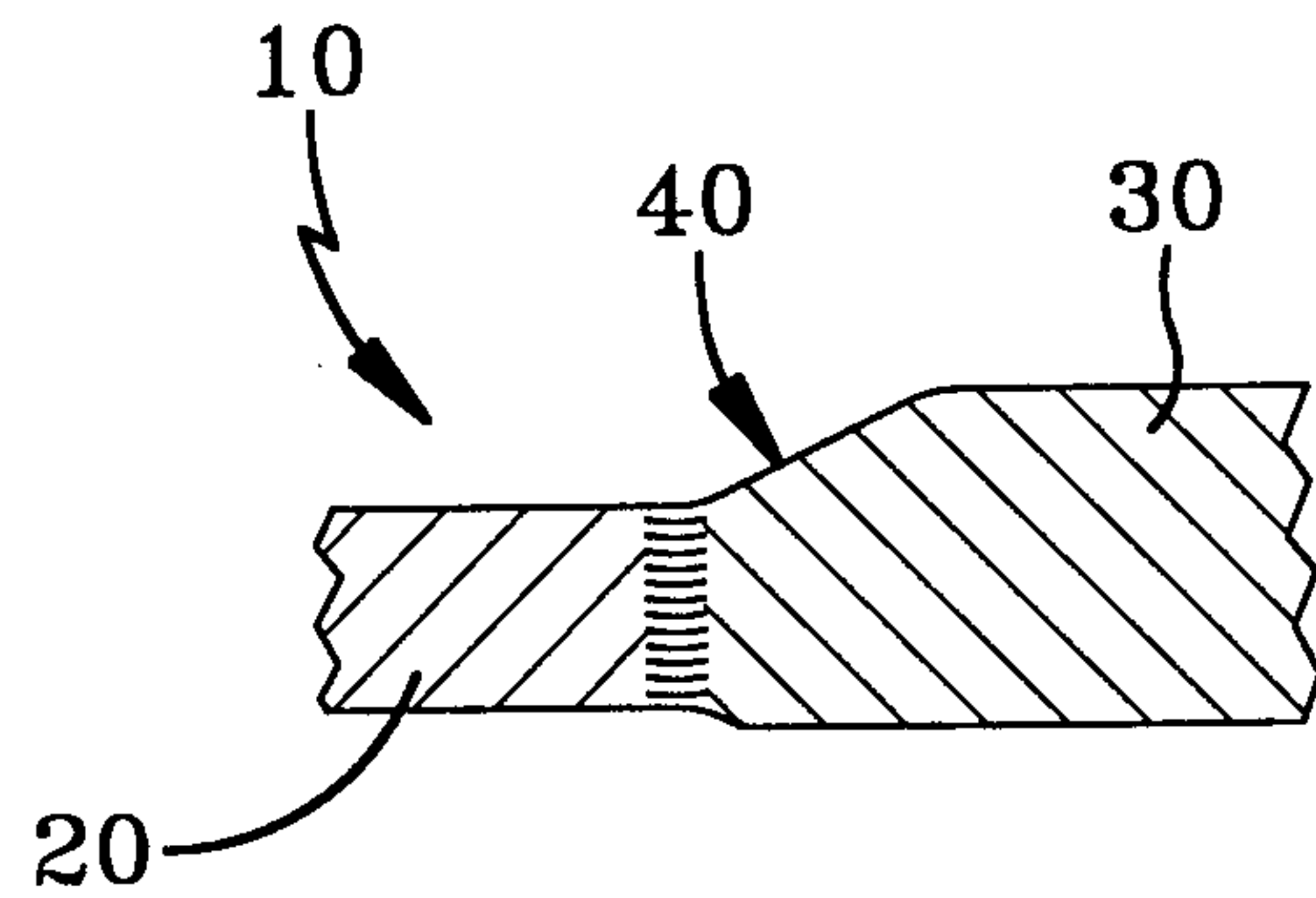


FIG-3

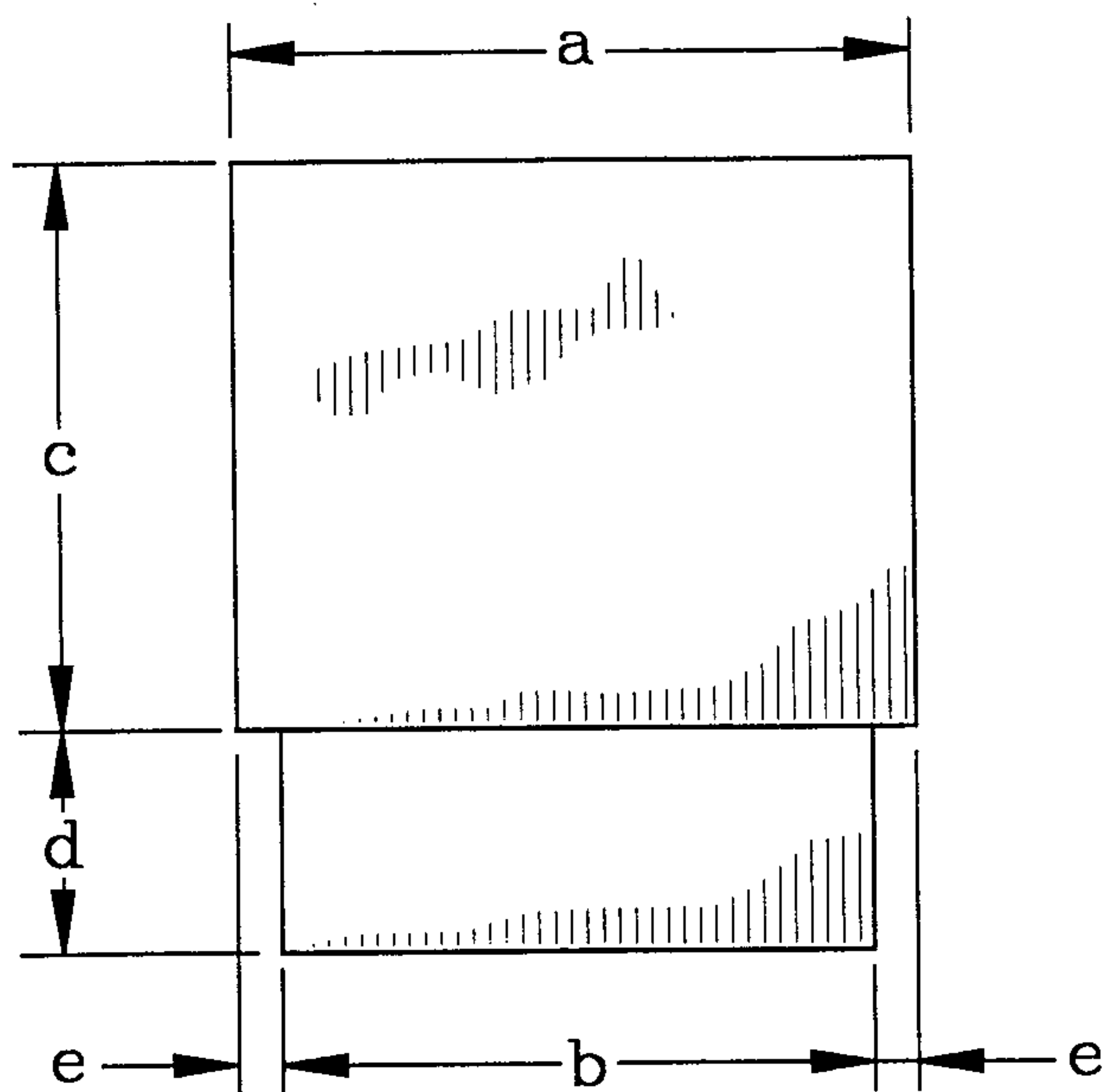


FIG-2a

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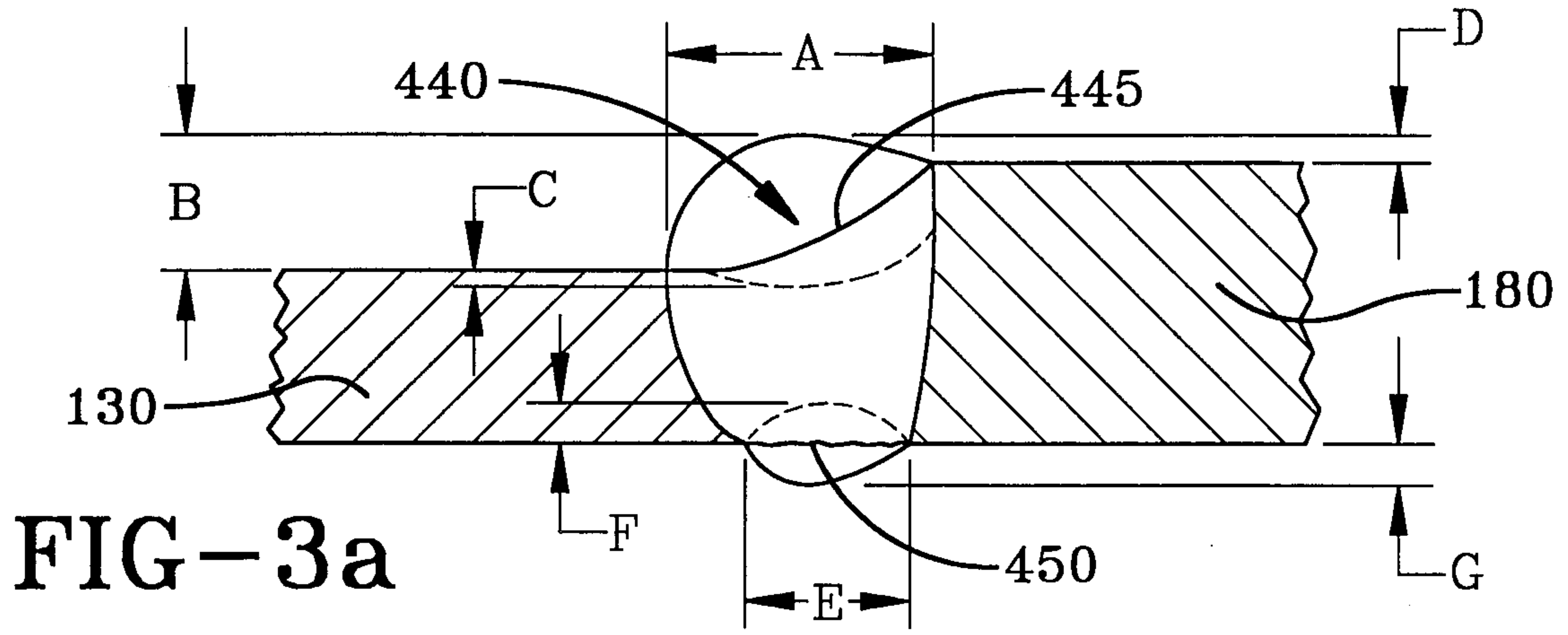


FIG-3a

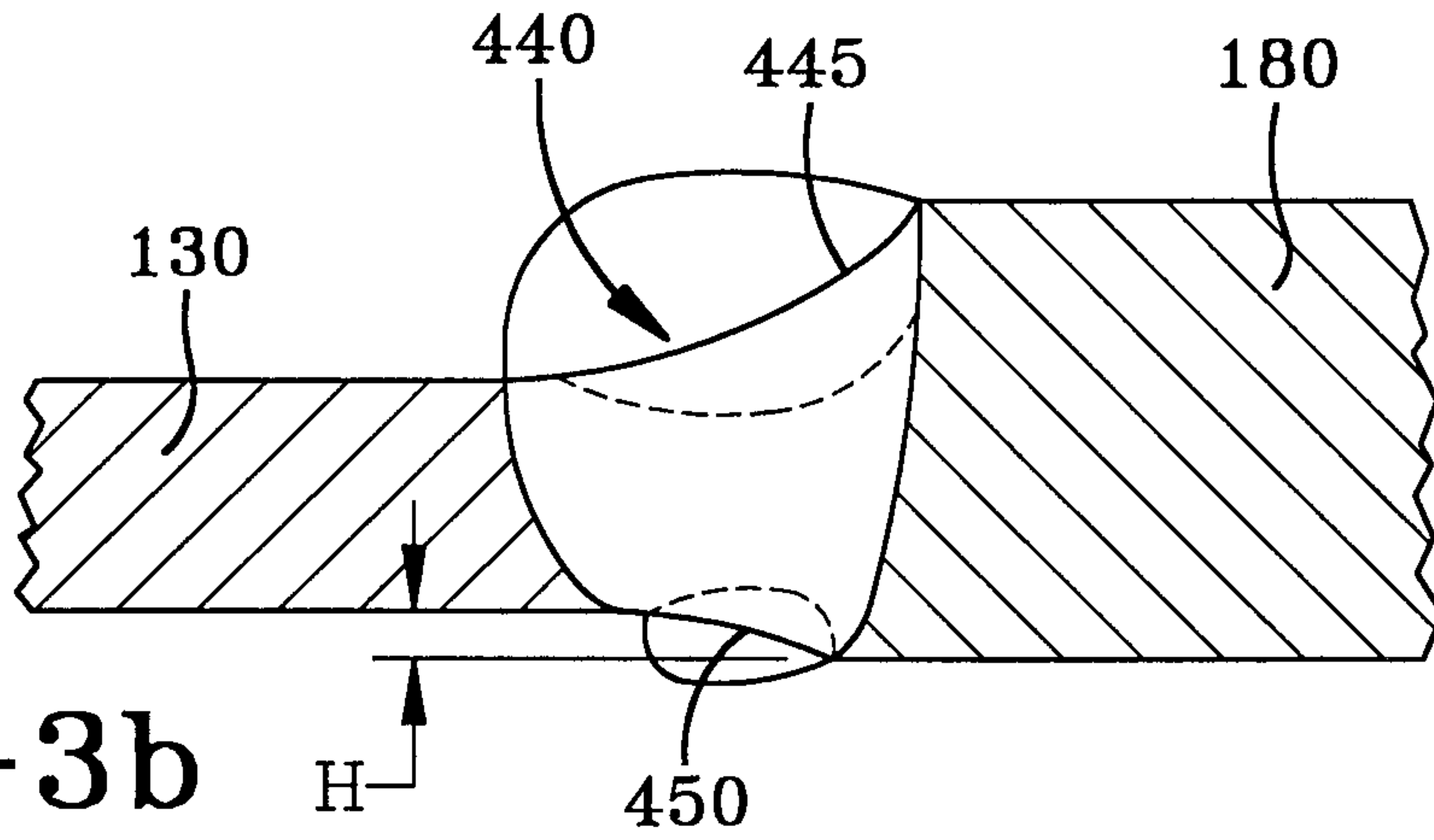


FIG-3b

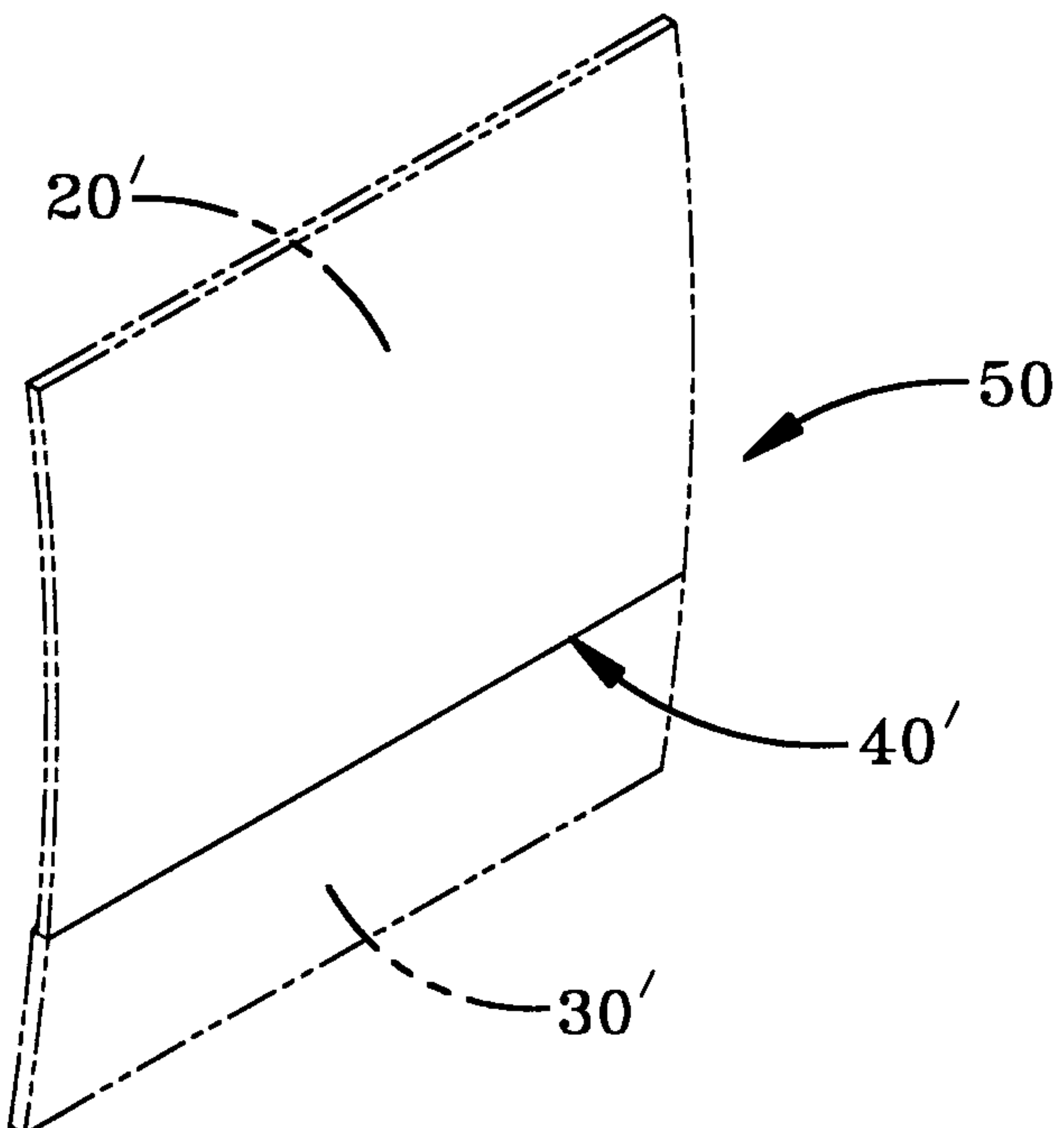
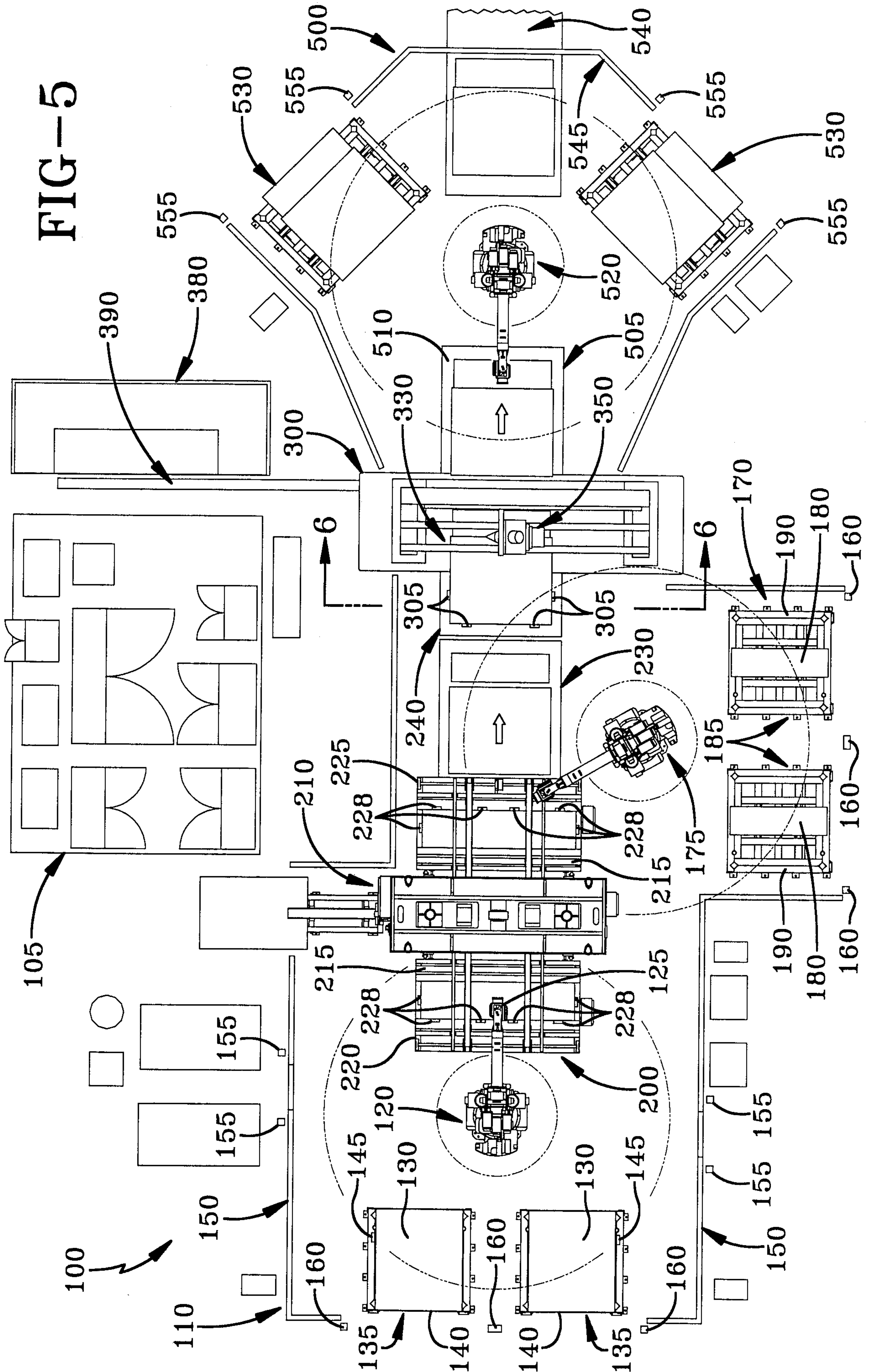


FIG-4

FIG-5



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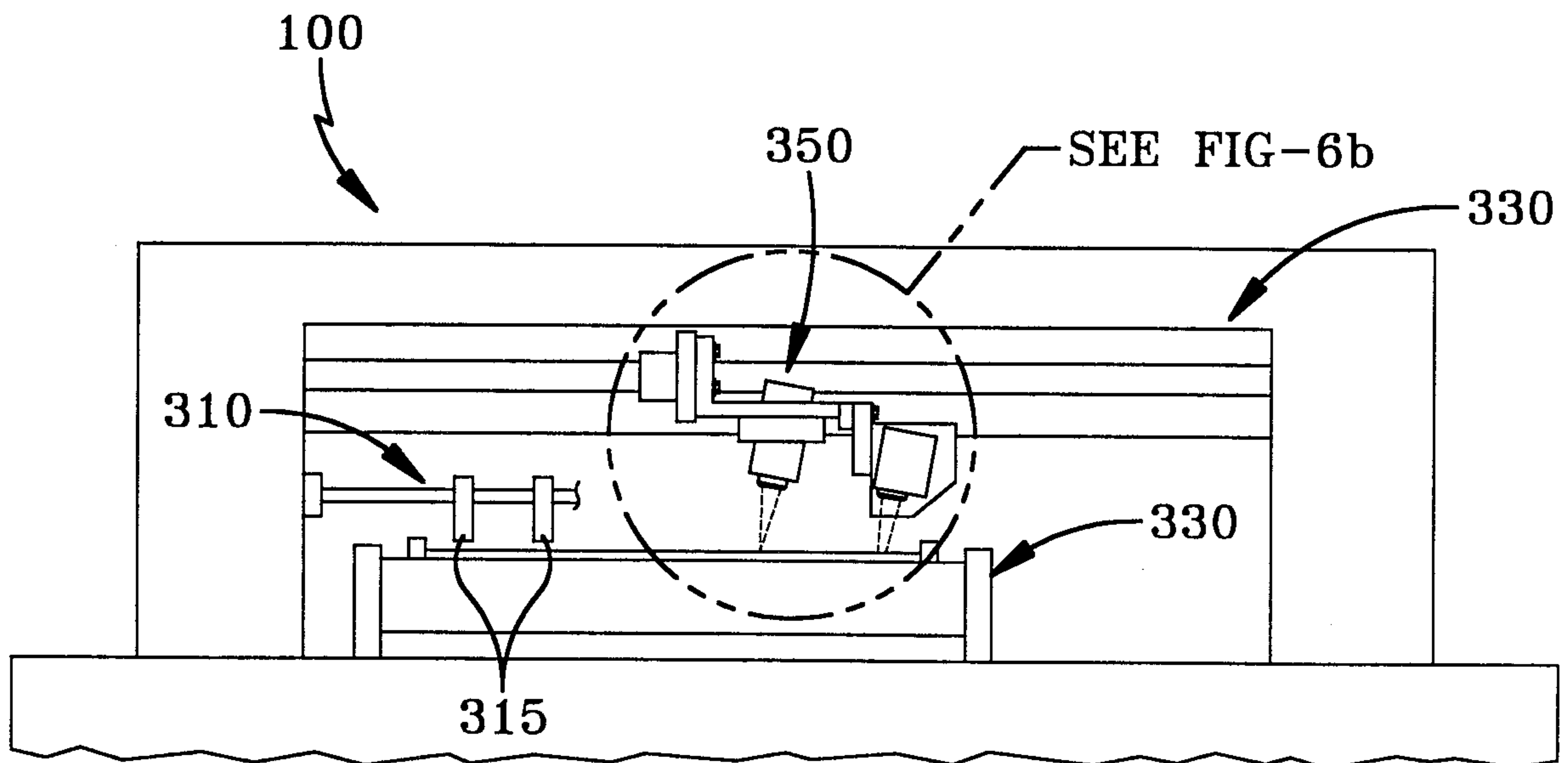


FIG-6a

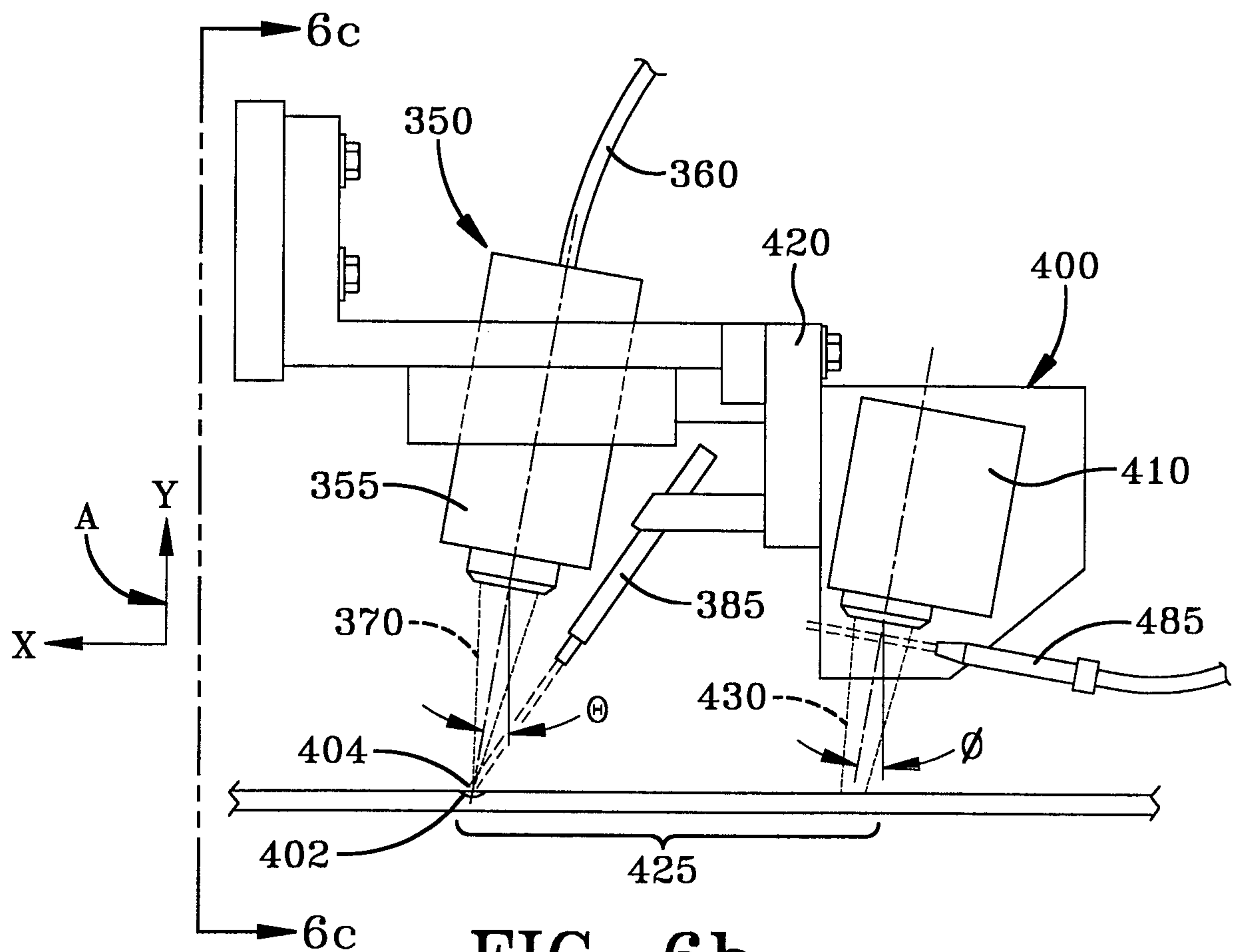


FIG-6b

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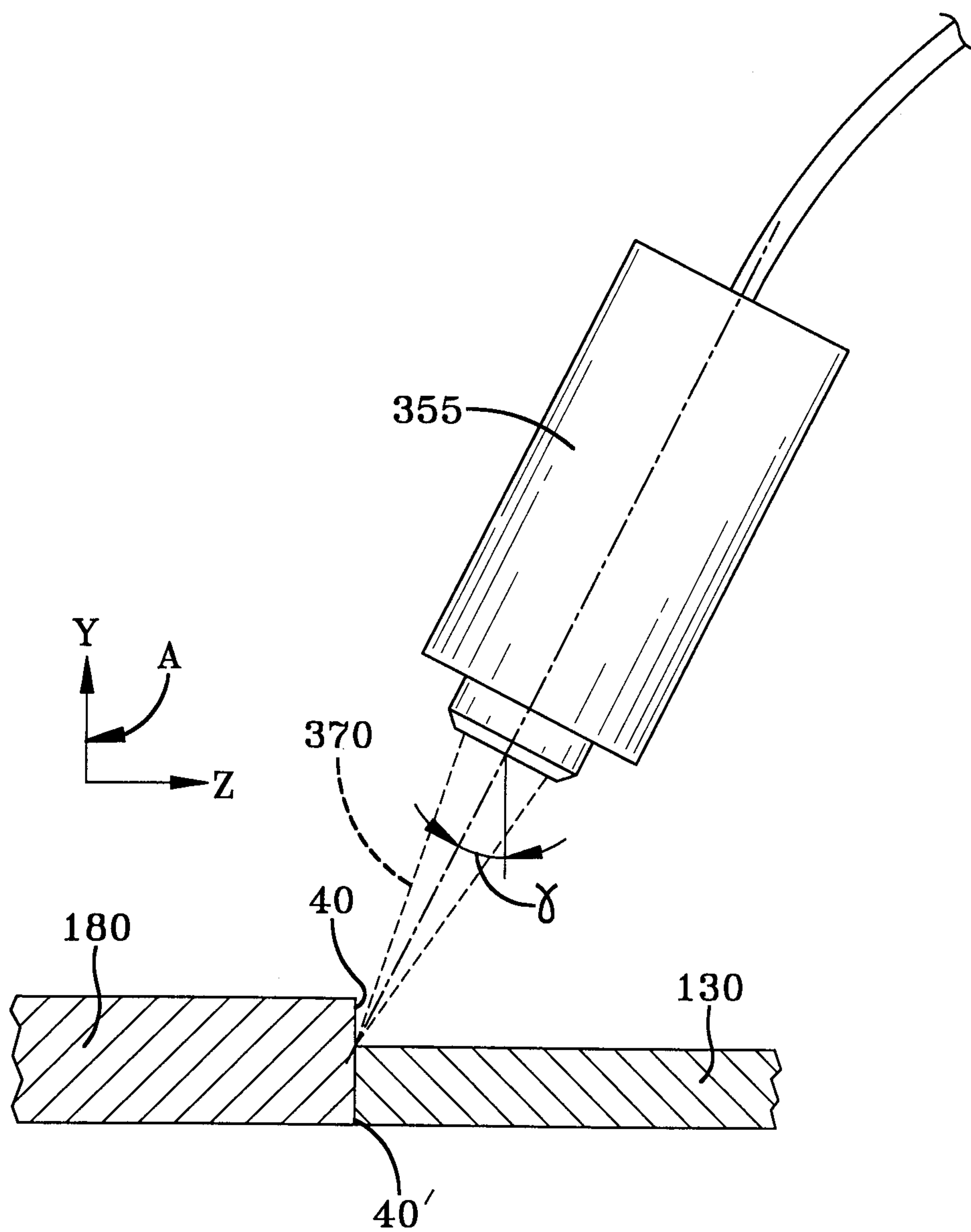


FIG-6c

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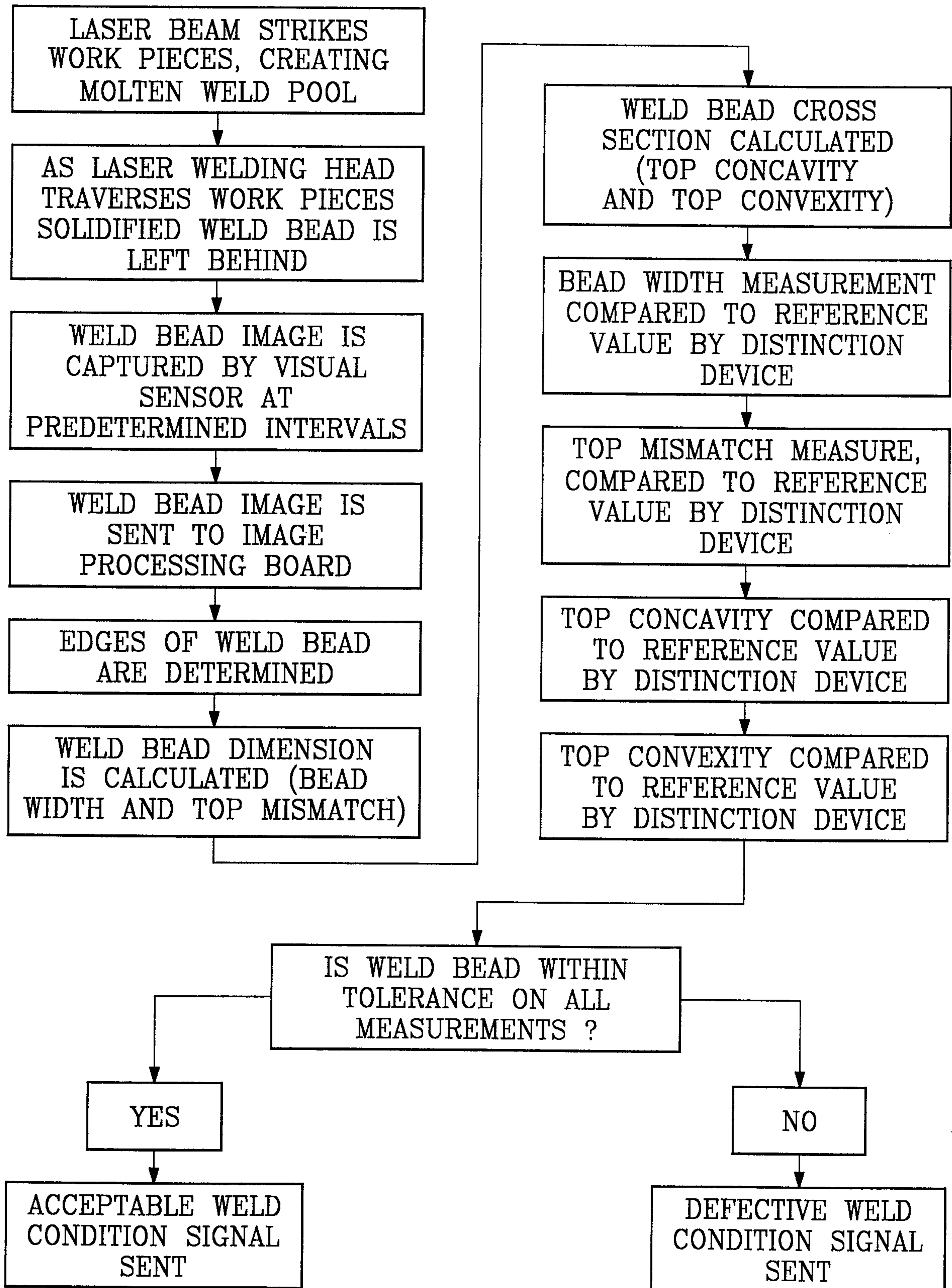
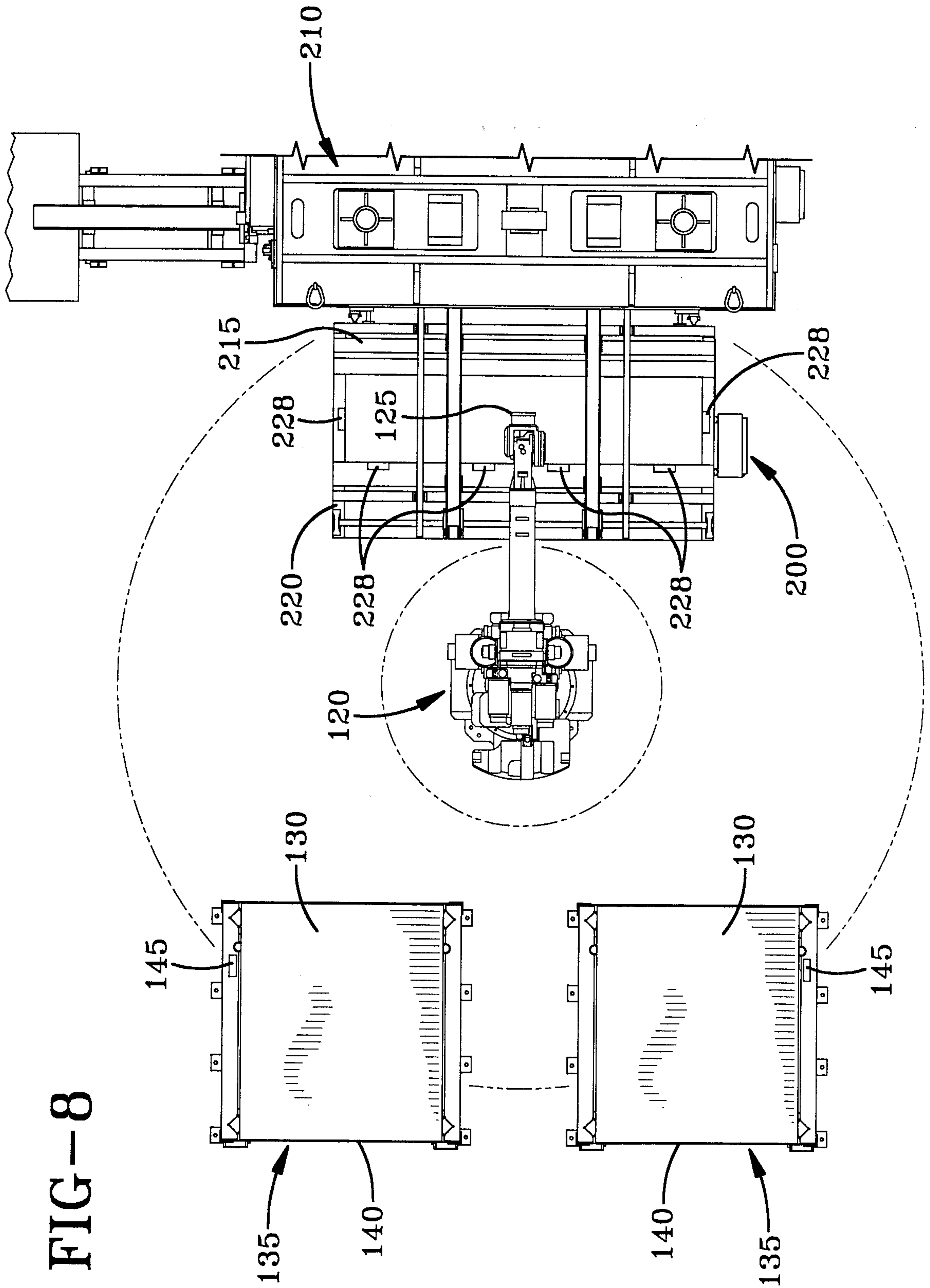
WELD INSPECTION PROCESS

FIG-7



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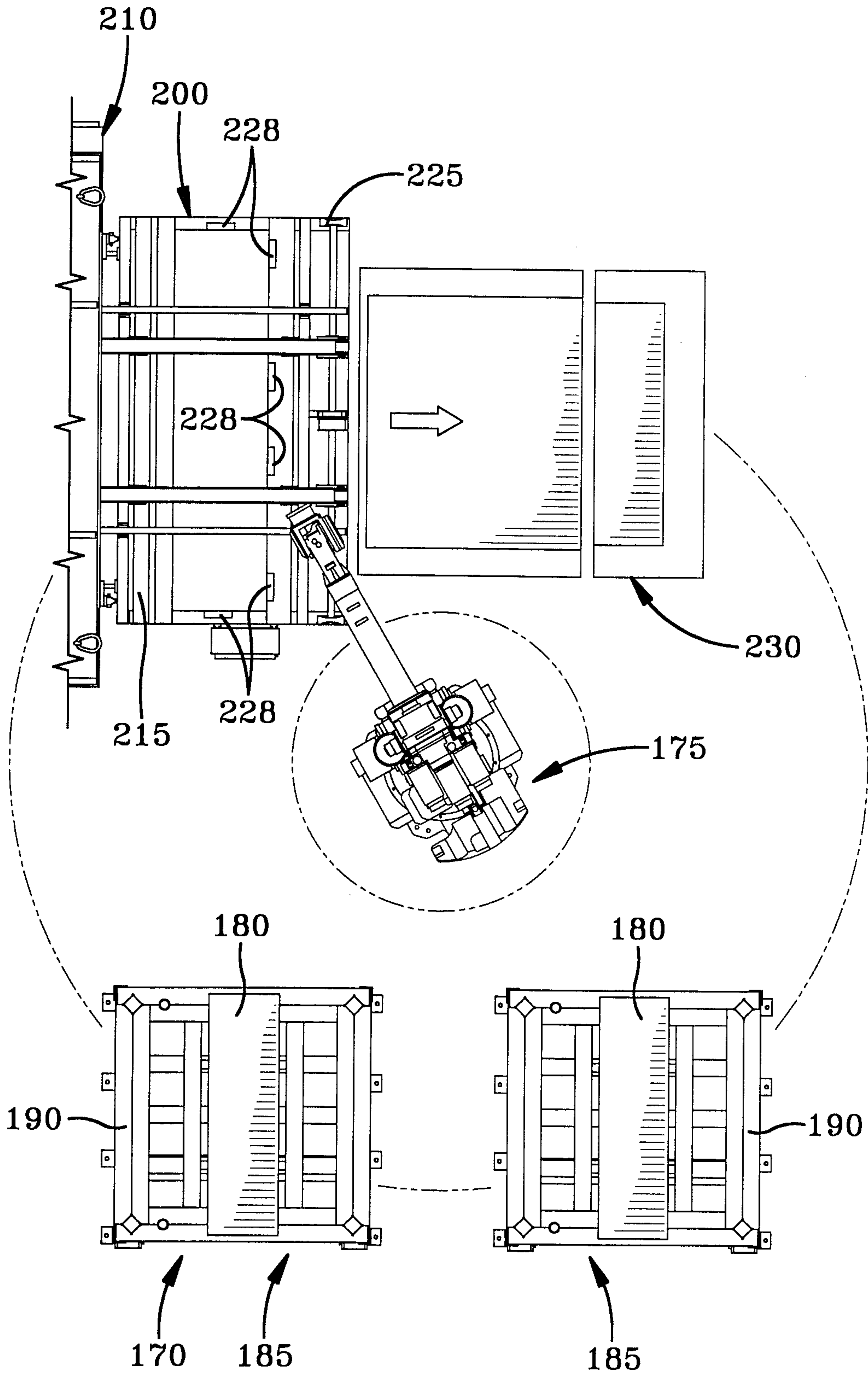


FIG-9

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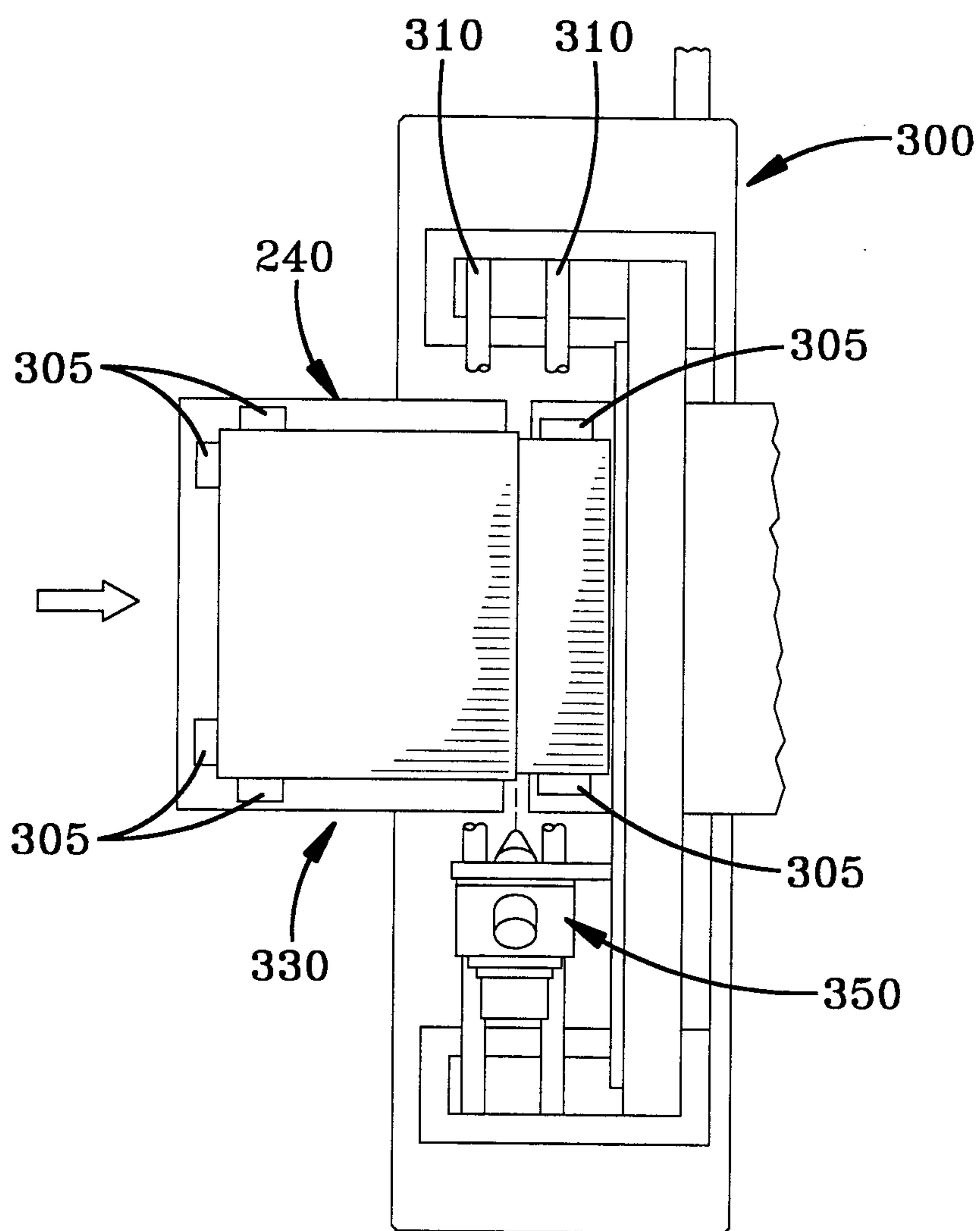


FIG-10

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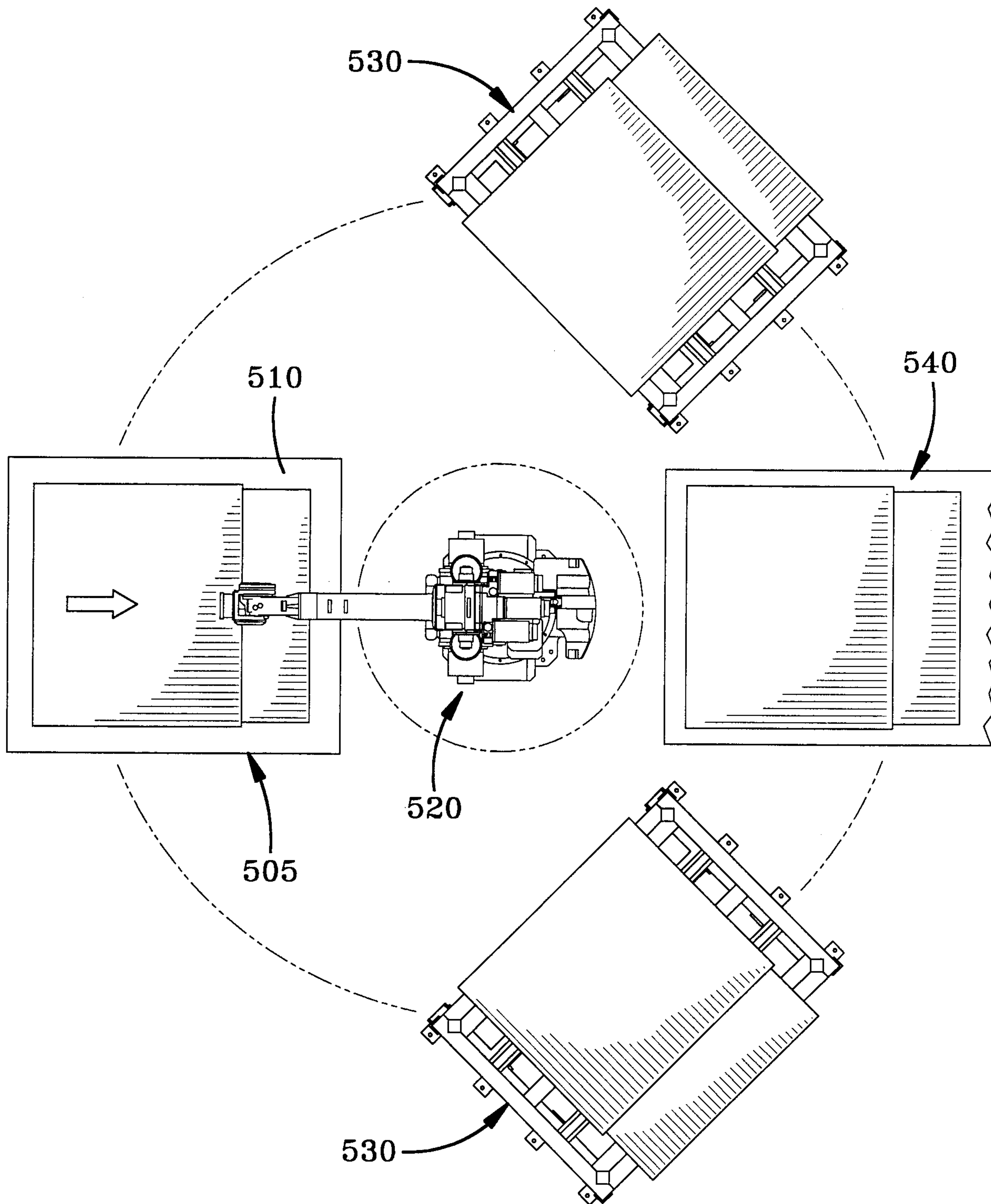


FIG-11

