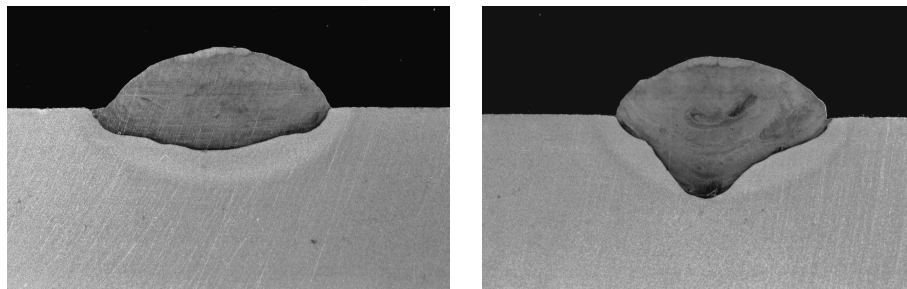


Figure 7.12: - An example of an alternating low-high penetration profile. Such a profile can be obtained at the end of an overlay that is deposited bi-directionally if there are no time delays to allow for cooling, or if the cooling is inadequate. Deposition proceeded from right to left.



Figures 7.13: - An example of a sudden variation in the penetration profile. These two sections were taken from the same single-bead deposit and were separated by only 10mm of travel.