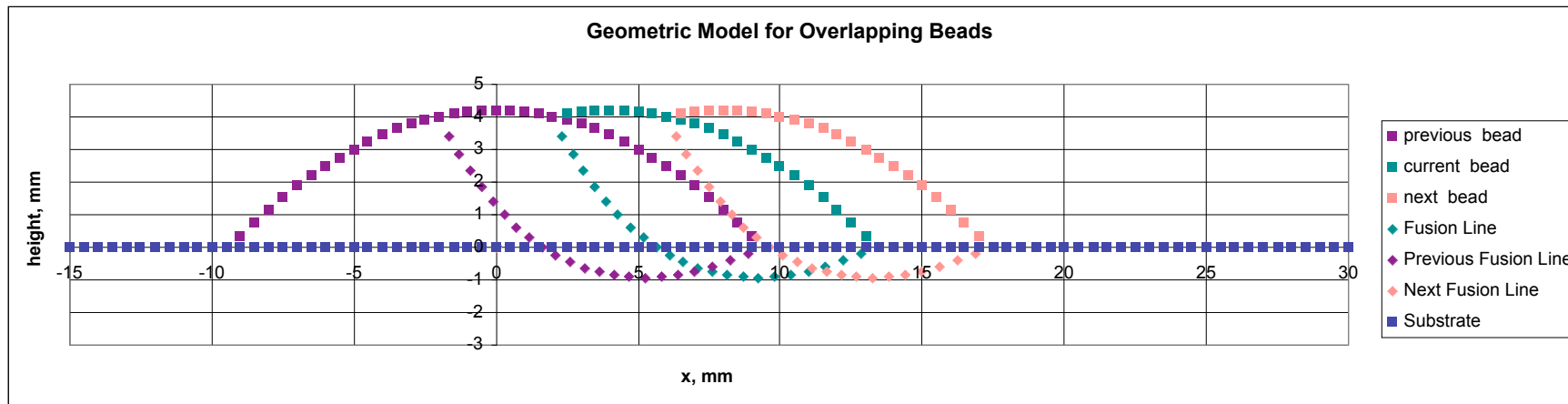


**Figure 8.2(a):** - The output of the geometric spreadsheet program for welding condition C (see section 6.6), which produced a 4mm high overlay. The travel speed was 400mm/min.



**Figure 8.2(b):** - The output of the geometric spreadsheet program for welding condition E (see section 6.6), which produced a 4mm high overlay. The travel speed was 800mm/min. Comparison with condition C (shown in Figure 8.2(a)), reveals that a significant reduction in penetration and hence dilution may be achieved by operating with a high-travel-speed. The deposition rates were the same for both conditions.