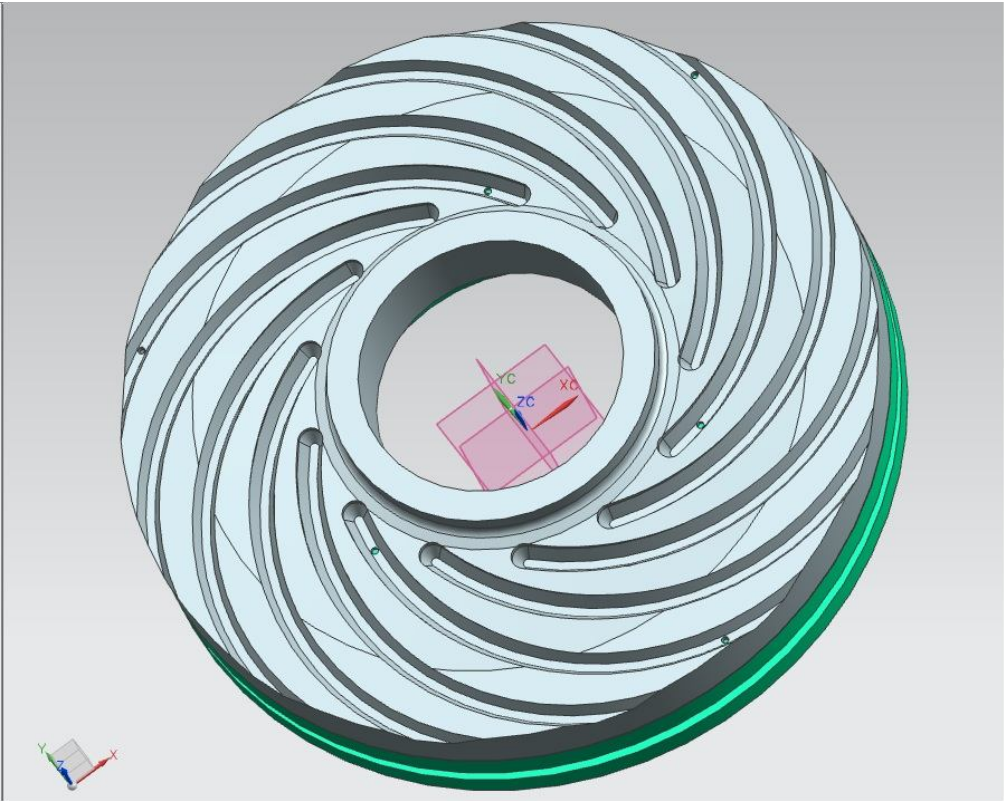
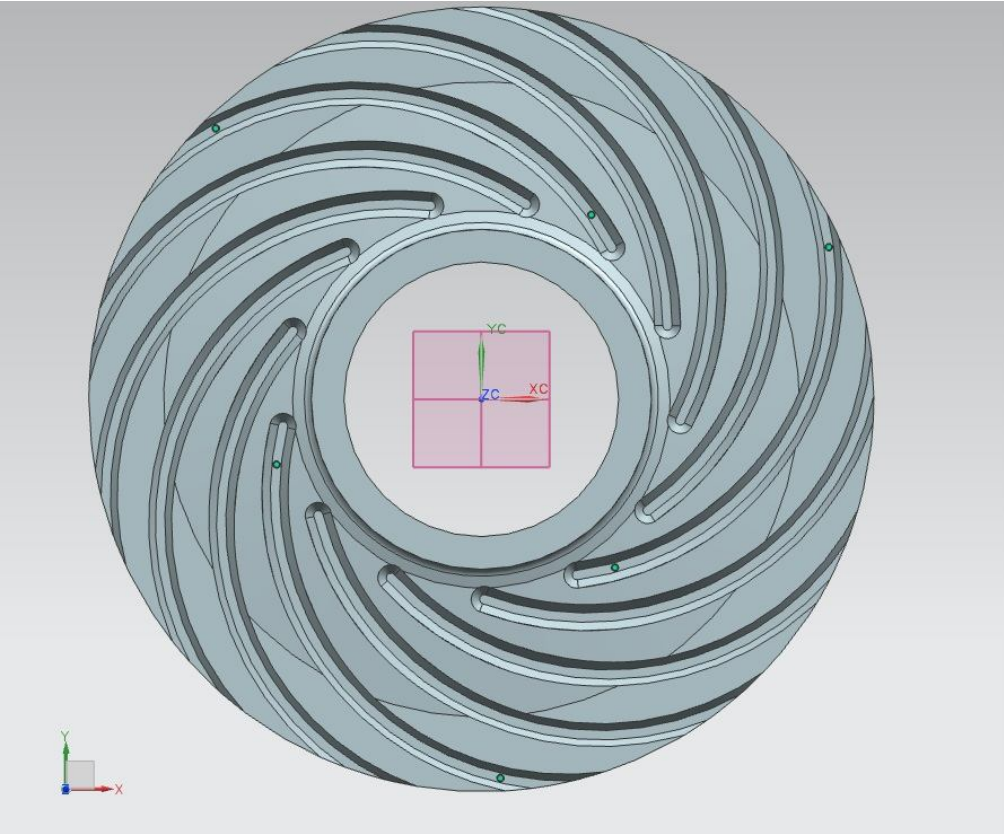
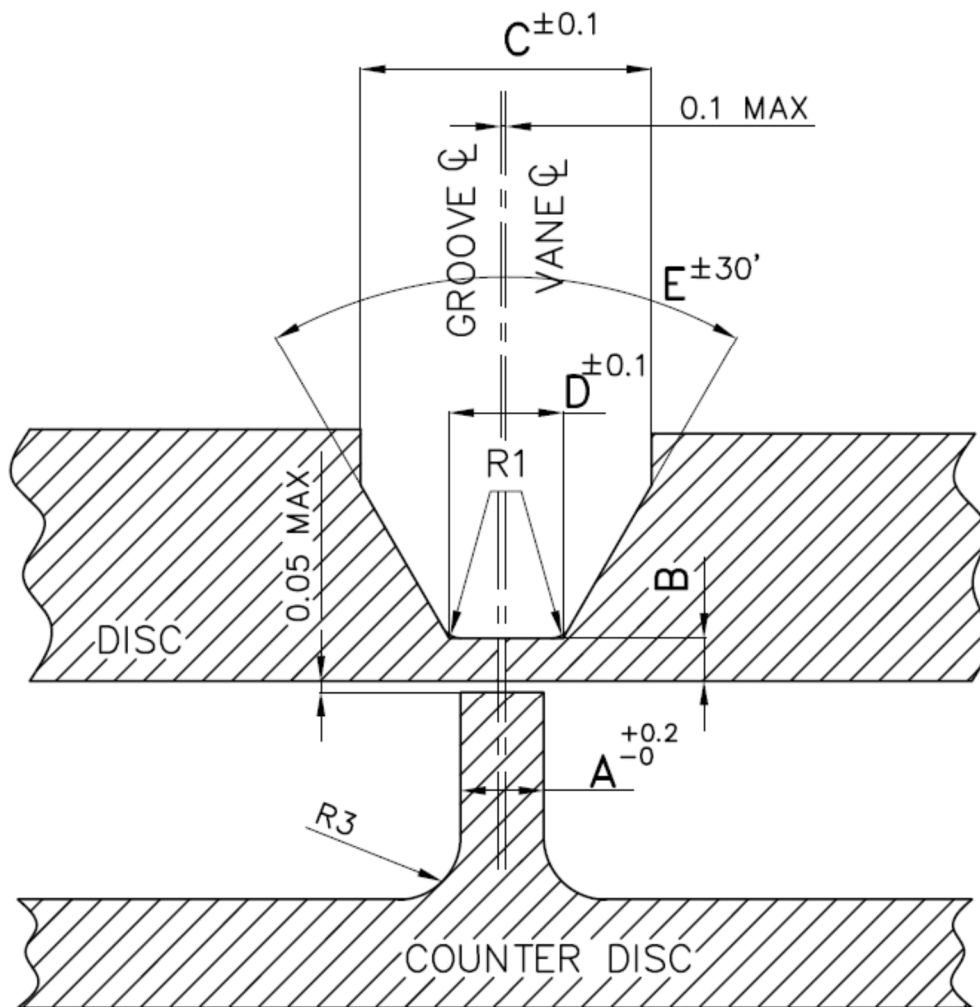


Externally Welded Impeller





1. Profile of Weld Groove

VAR NO	VANE THICKNES A	GROOVE BOTTOM THICKNESS-B			GROOVE TOP WIDTH-C	GROOVE BOTTOM WIDTH-D	GROOVE ANGLE-E°
		MATERIAL					
		HY19377 (KMNCOGNE)	HY19391 (X12Cr13)	HY19395 (FV520B)			
01	4	1.5 ± 0.05	1.5 ± 0.05	1.5 ± 0.05	14	5	60°



2. Robotic Work-Cell being used for TIG welding



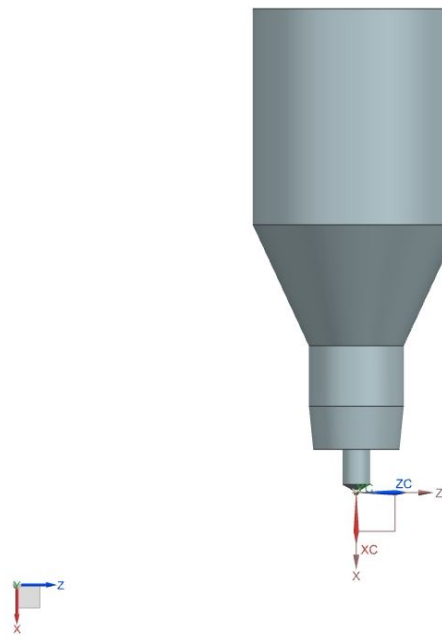


Fig 3. 6mm Ceramic Nozzle

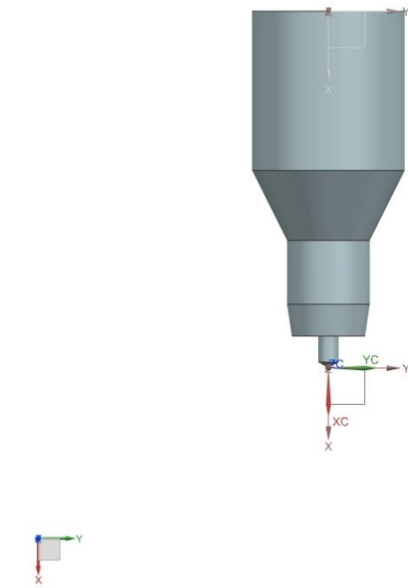


Fig 4. 8mm Ceramic Nozzle

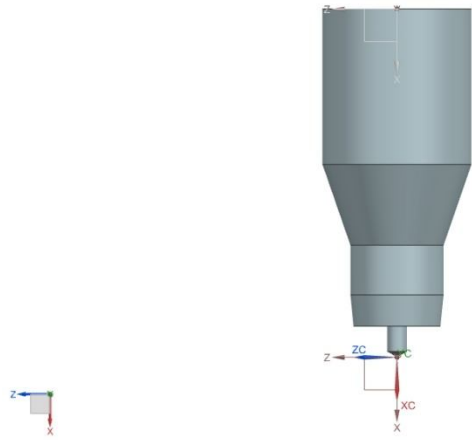


Fig 4. 10mm Ceramic Nozzle