

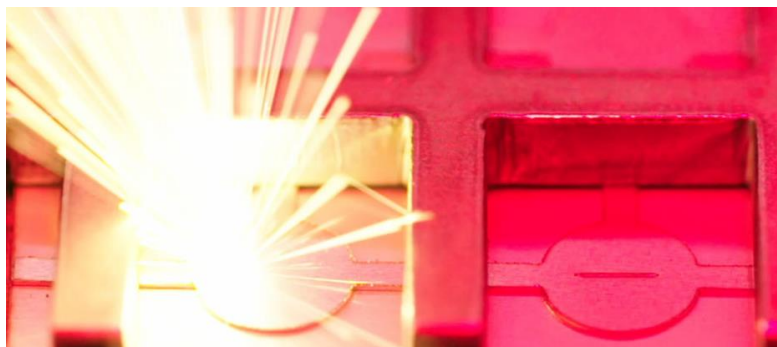
Precitec Graph Documentation

Welding Contour out of Buffer without Image with LWM

■ Changelog

Date	Version	Autor	Tested on	Description
2023-03-07	A	Wre	5.19.13	New documentation

■ Description



Loads a Contour from the Buffer and welds it without providing images but with the LWM data. Ideal for automatic production cycles, since turning off the camera in the welding step will limit the amount of data and increase system stability.

■ Parameter

<u>G00 Loading Buffer values</u>			
NAME	DEFAULT VALUE	Description	UserLevel
04 Contour → Seam-Series-Offset	0	Number of Seam-Series the Buffer should look back	GroupLeader
04 Contour → Seam-Offset	-2	Number of Seams the Buffer should look back	GroupLeader
09 Plausibility → Seam-Series-Offset	0	Number of Seams the Buffer should look back	GroupLeader
09 Plausibility → Seam-Offset	-1	Number of Seam-Series the Buffer should look back	GroupLeader
<u>G02 Add plausibility to trigger for welding</u>			
NAME	DEFAULT VALUE	Description	UserLevel
00 Ignore Plausibility 0 = do not ignore; 1 = ignore → Number	0	Possibility to turn off the plausibility check and not skip the welding	Operator
<u>G04 LWM Signals</u>			
NAME	DEFAULT VALUE	Description	UserLevel
00 Software Gain Plasma → Number	2.27	Software Gain for the Plasma signal	GroupLeader
01 Software Gain Temperature → Number	3	Software Gain for the Temperature signal	GroupLeader
02 Software Gain Back Reflection → Number	8	Software Gain for the Back Reflection signal	GroupLeader
03 Software Gain Laser Power → Number	3.69	Software Gain for the Laser Power signal	GroupLeader
04 Max Laser Power → Number	4000	Maximum Laser Power	GroupLeader
05 LowPass Plasma → Kind of low pass	Mean	Choose between a floating mean, median, maximum, or minimum filter.	GroupLeader

05 LowPass Plasma → Filter length	1	Choose the Filter length the floating low pass filter should be applied to.	GroupLeader
06 LowPass Temperature → Kind of low pass	Mean	Choose between a floating mean, median, maximum, or minimum filter.	GroupLeader
06 LowPass Temperature → Filter length	1	Choose the Filter length the floating low pass filter should be applied to.	GroupLeader
07 LowPass Back Reflection → Kind of low pass	Mean	Choose between a floating mean, median, maximum, or minimum filter.	GroupLeader
07 LowPass Back Reflection → Filter length	1	Choose the Filter length the floating low pass filter should be applied to.	GroupLeader
08 LowPass Laser Power → Kind of low pass	Mean	Choose between a floating mean, median, maximum, or minimum filter.	GroupLeader
08 LowPass Laser Power → Filter length	1	Choose the Filter length the floating low pass filter should be applied to.	GroupLeader

■ Input Buffers

Value	Slot Number
Contour	4
Plausibility 0 = good Plausibility 1 = bad Plausibility	9

■ Results

Value	Result Enum	Result Name
LWM Plasma	737	Plasma
LWM Temperature	738	Temperature
LWM Back Reflection	739	Back Reflection

LWM LPM Laser power	740	Laser Power
Plausibility 0 = good Plausibility 1 = bad Plausibility	555	Plausibility error