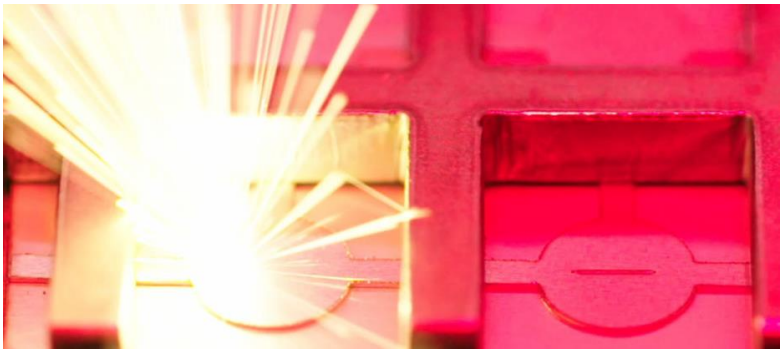
Precitec Graph Documentation

Welding Contour out of Buffer with 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 with providing images and LWM data. Should be used for R&D purposes and not full-automatic product cycles, since the camera will generate a lot of data which might overflow the system. For automatic processes refer to the welding algorithms without camera.

- **Parameter**

G00 Loading Buffer values			
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
G02 Add plausibility to trigger for welding			
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
G04 LWM Signals			
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