

Cooling Rate (K/s)

1.4
1.3
1.2
1.1

2 KHz

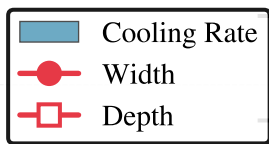
8 KHz

20 KHz

50 KHz

CW

Case



175
150
125
100
75
50

Melt Pool Dimensions (μm)

