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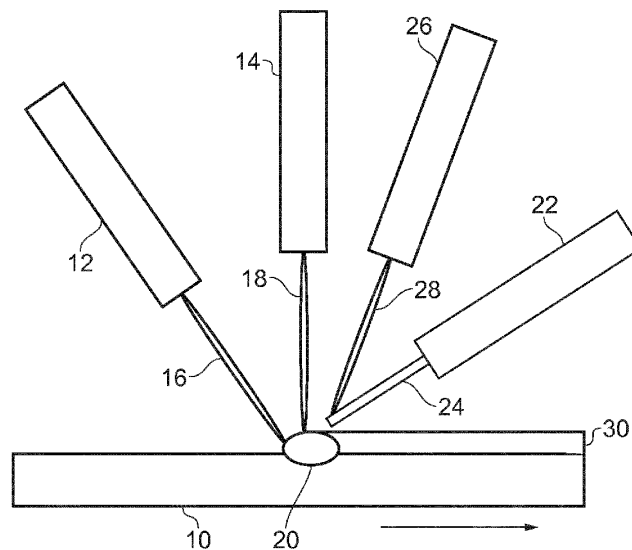


FIG. 1

(57) Abstract: A method of producing a 3D article by additive manufacture is provided. The method includes the steps of: forming a melt pool in an already-existing part of the article, and moving the melt pool relative thereto; feeding a directed feedstock into the moving melt pool to deposit and fuse a layer of material on the already-existing part; and repeating the forming and moving and feeding steps to build up successive layers of material. In performance of the forming and moving step: a first energy source impinges at a first region of the already-existing part which moves with and leads the melt pool, whereby the first energy source initiates the formation of the melt pool; and a second energy source impinges at a second region on the already-existing part which moves with and follows the first region, whereby the second energy source grows the lateral width of the melt pool before the feedstock is fed therein.

[Continued on next page]

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