

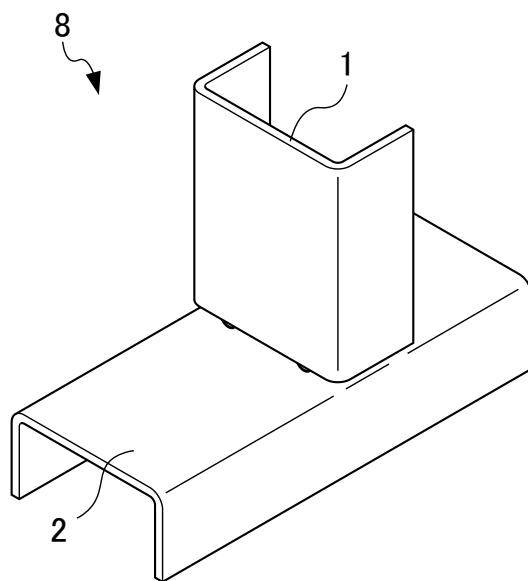


FIG. 1A

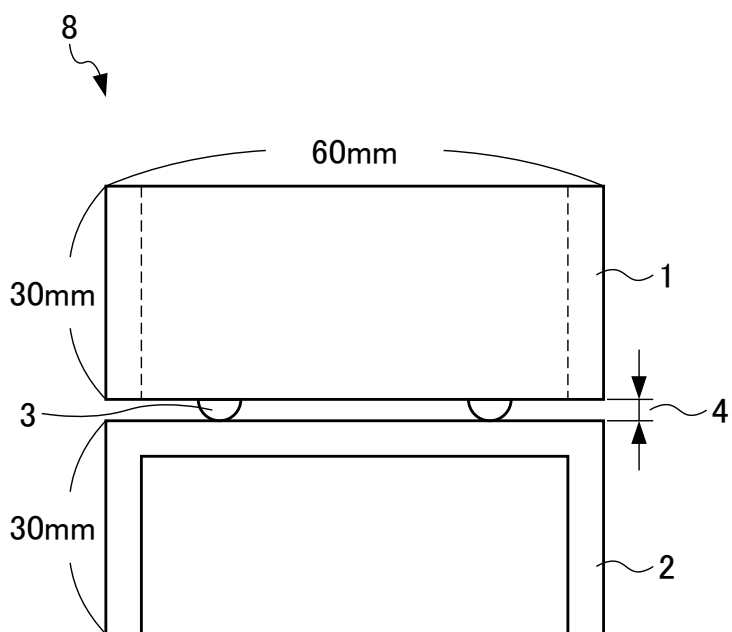


FIG. 1B

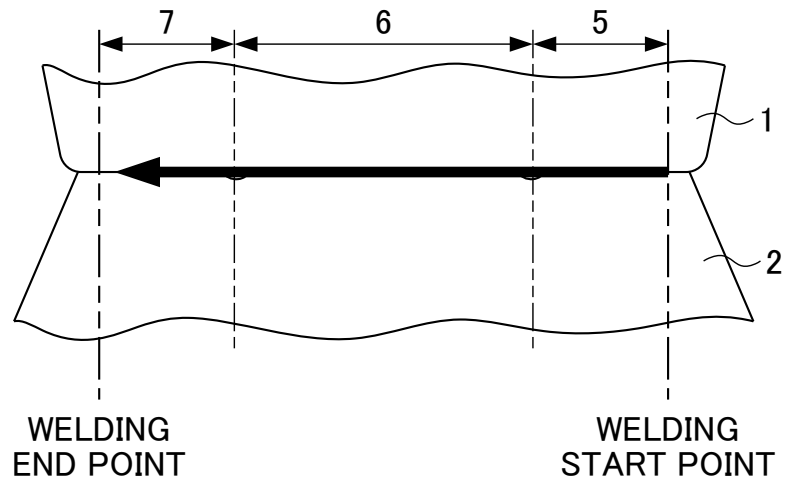


FIG. 2A

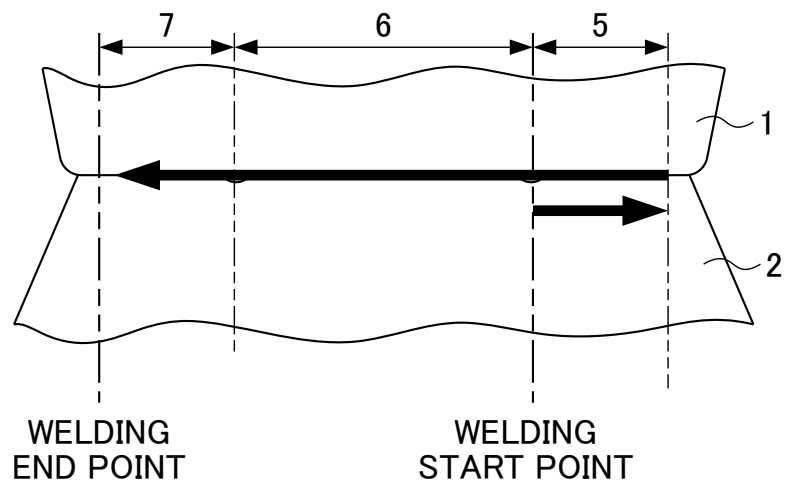
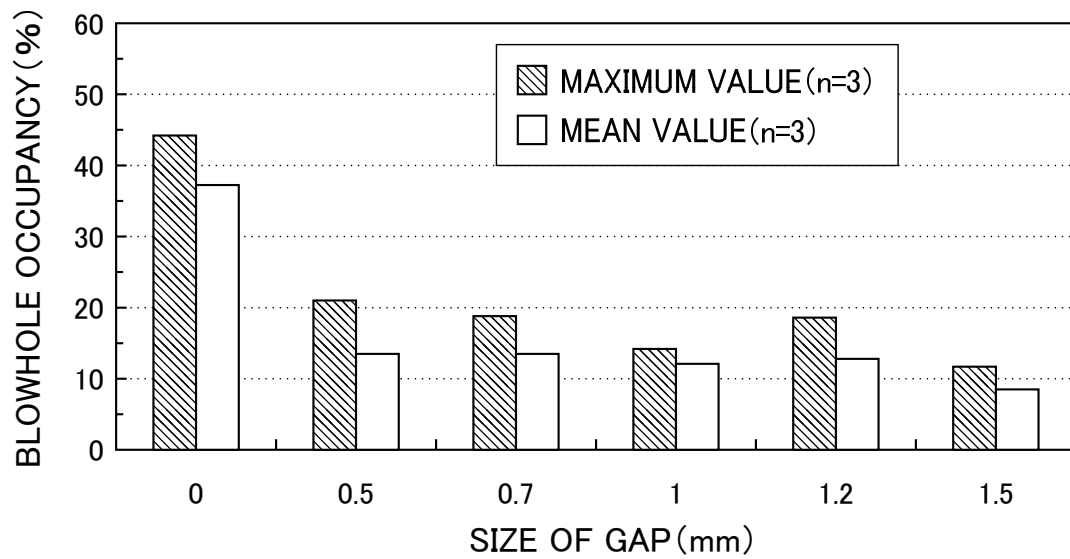
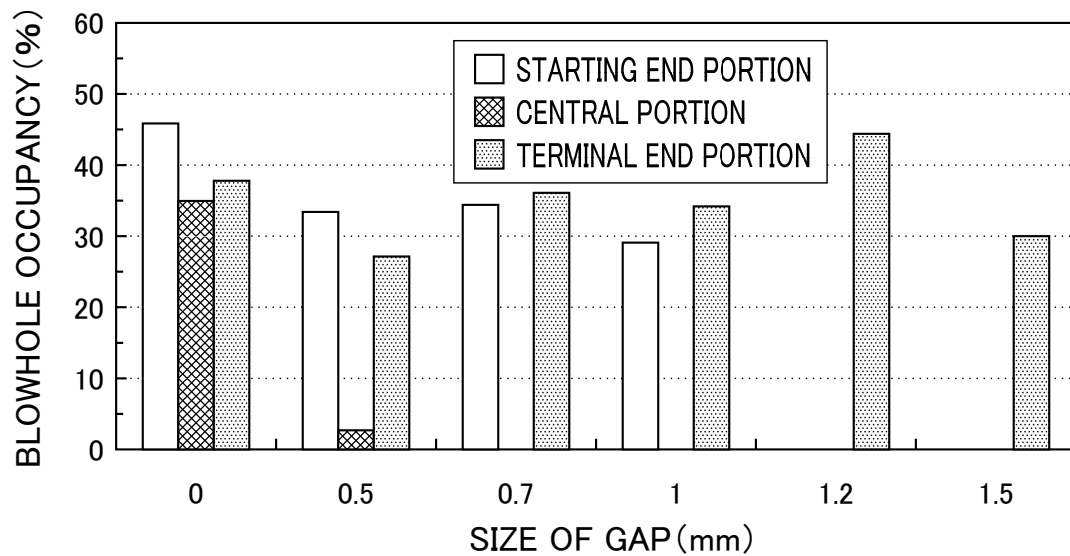


FIG. 2B

**FIG. 3A**

BLOWHOLE OCCUPANCY OVER FULL LENGTH OF WELDING SECTION

**FIG. 3B**BLOWHOLE OCCUPANCY FOR EACH WELDING AREA
<MEAN VALUE OF N = 3>

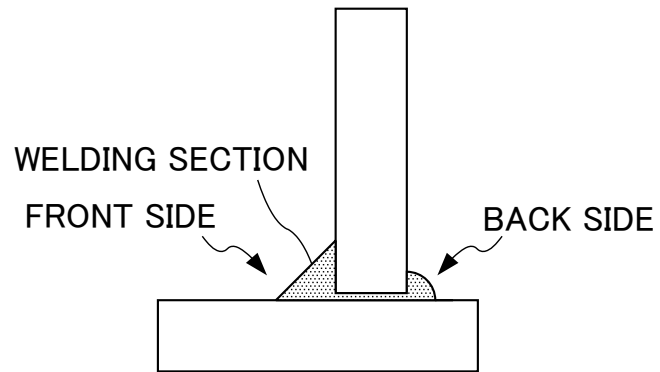


FIG. 4