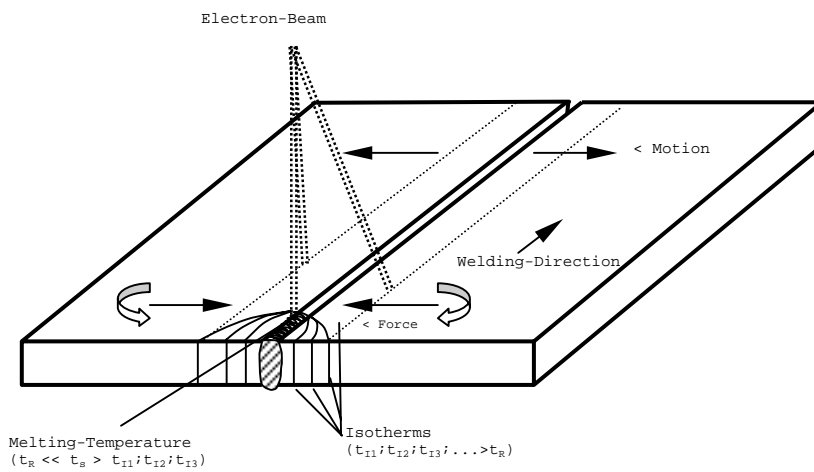


a.



b.

Ad a:
"Conventional" EB-Welding-Mode

Ad b:
Beam "Flow-Mode" for Preheating the Part and Flatten the Temperature Gradient