

### Welding depth by material

Material	Usual welding method	Material thickness, mm	Laser welding machine power, W				
			500	800	1000	1500	2000
Aluminium	Nitrogen, N <sub>2</sub>	1			√	√	√
		1.2			√	√	√
		1.5				√	√
		2					√
		2.5					√
Stainless steel	Argon, Ar	0.5	√	√	√	√	√
		0.8		√	√	√	√
		1		√	√	√	√
		1.2		√	√	√	√
		1.5			√	√	√
		2				√	√
		2.5					√
		3					√
Carbon steel	Carbon dioxide, CO <sub>2</sub>	0.5	√	√	√	√	√
		0.8		√	√	√	√
		1			√	√	√
		1.2			√	√	√
		1.5			√	√	√
		2				√	√
		2.5					√
		3					√
Galvanized sheet	Argon, Ar	0.5	√	√	√	√	√
		0.8	√	√	√	√	√
		1		√	√	√	√
		1.2			√	√	√
		1.5				√	√
		2					√
		2.5					√