



US005121339A

United States Patent [19]

[11] Patent Number: **5,121,339**

Jenuwine et al.

[45] Date of Patent: **Jun. 9, 1992**

[54] LASER WELD FAULT DETECTION SYSTEM

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[21] Appl. No.: **568,499**

[22] Filed: **Aug. 16, 1990**

[51] Int. Cl.⁵ **G01N 29/14; B23K 26/00**

[52] U.S. Cl. **364/507; 364/552; 219/130.01**

[58] Field of Search **364/505, 506, 507, 551.01, 364/551.02, 550, 552, 575, 576, 726, 574, 474.08, 477; 73/587, 588, 603, 632; 219/130.01**

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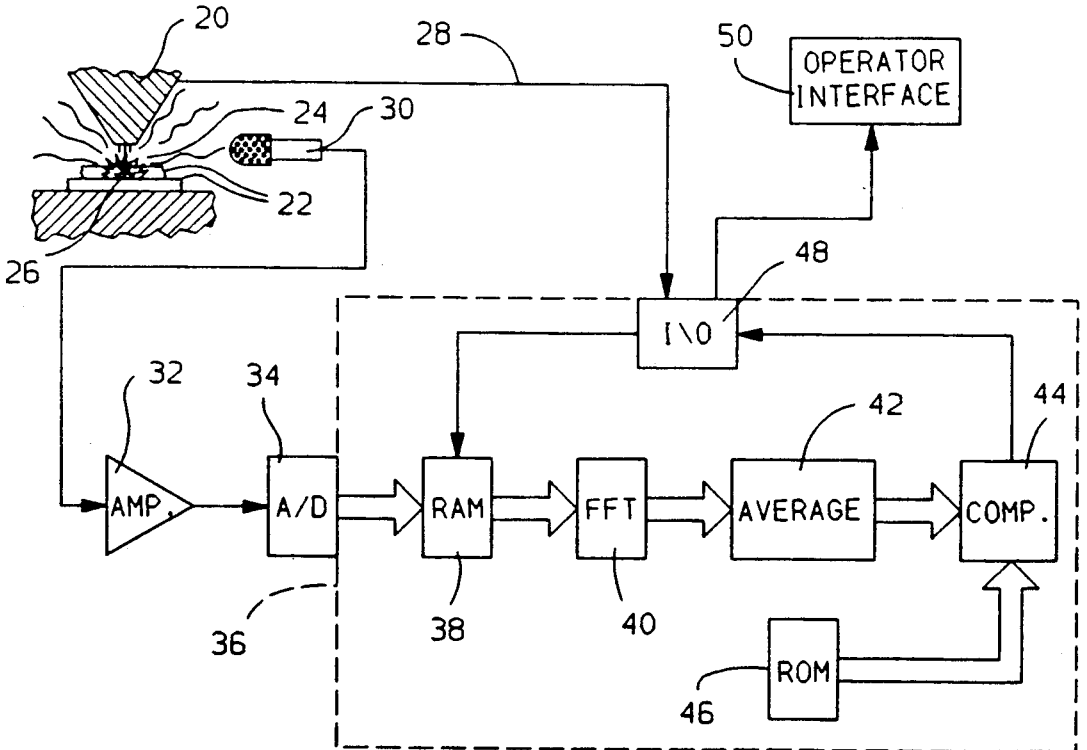
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[57] ABSTRACT

An on-line, non-destructive method and apparatus monitors a welding process and detects faulty welds by analyzing the average frequency of the airborne radiation emitted from a weld during the welding process. A sequence of measured average frequency values corresponding to sequential blocks of time during the weld are individually compared to a predetermined frequency threshold value. Overall weld integrity is discerned by comparing the number of average frequency values exceeding the threshold value to the number of average frequency values not exceeding the threshold value.

7 Claims, 2 Drawing Sheets



SIGNAL PROCESSING AND STORAGE SYSTEM