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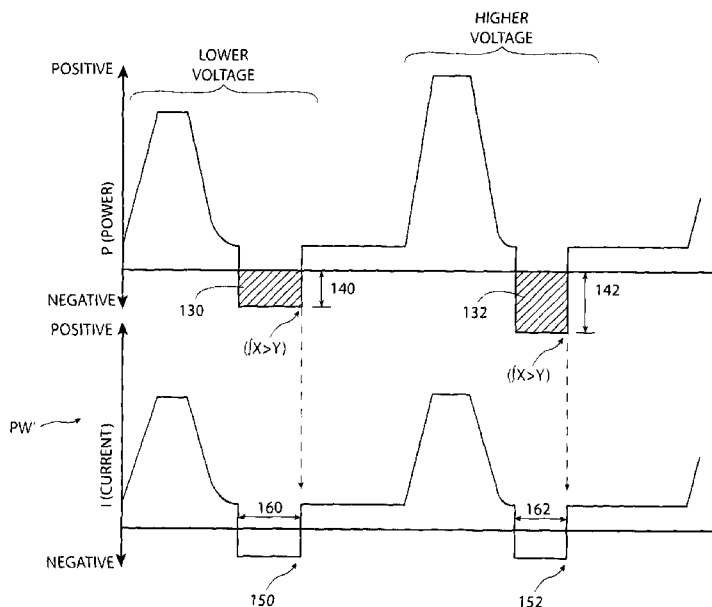


FIG. 6

(57) Abstract: An electric arc welder (A) including a high speed switching power supply (10) with a controller (60) for creating high frequency current pulses with negative polarity components through the gap (g) between a workpiece (W) and a welding wire (20) advancing toward the workpiece (W). Molten metal droplets (D) are quickly created during negative polarity portions (120) of the weld cycle. Welding controls include integrating a parameter during the negative polarity portions (120) to determine when a desired amount of energy has been generated at the welding wire (W). This energy is associated with a desired droplet (D) size for consistent droplet transfers to the workpiece (W).



# INTERNATIONAL SEARCH REPORT

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According to International Patent Classification (IPC) or to both national classification and IPC				
<b>B. FIELDS SEARCHED</b>				
Minimum documentation searched (classification system followed by classification symbols) B23K				
Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched				
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<b>C. DOCUMENTS CONSIDERED TO BE RELEVANT</b>				
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.		
X	US 2012/097656 A1 (PETERS STEVEN R [US]) 26 April 2012 (2012-04-26) paragraphs [0062] - [0064]; figure 11 -----	1-15		
X	EP 1 712 320 A2 (LINCOLN GLOBAL INC [US]) 18 October 2006 (2006-10-18) paragraph [0032]; figure 10 -----	1-15		
X	EP 1 439 021 A2 (LINCOLN GLOBAL INC [US]) 21 July 2004 (2004-07-21) paragraph [0025]; figures 1, 2, 5, 6 -----	1-15		
<input type="checkbox"/> Further documents are listed in the continuation of Box C. <input checked="" type="checkbox"/> See patent family annex.				
* Special categories of cited documents : <table style="width: 100%; border: none;"> <tr> <td style="width: 50%; border: none; vertical-align: top;">                     "A" document defining the general state of the art which is not considered to be of particular relevance                      "E" earlier application or patent but published on or after the international filing date                      "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)                      "O" document referring to an oral disclosure, use, exhibition or other means                      "P" document published prior to the international filing date but later than the priority date claimed                 </td> <td style="width: 50%; border: none; vertical-align: top;">                     "T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention                      "X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone                      "Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art                      "&amp;" document member of the same patent family                 </td> </tr> </table>			"A" document defining the general state of the art which is not considered to be of particular relevance "E" earlier application or patent but published on or after the international filing date "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified) "O" document referring to an oral disclosure, use, exhibition or other means "P" document published prior to the international filing date but later than the priority date claimed	"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention "X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone "Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art "&" document member of the same patent family
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Information on patent family members

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