



### 1. Welding line inline control on stainless steel tubes

A welding line on stainless steel tubes should be inline controlled. For this purpose a color sensor type **SPECTRO-3-FIO-JR** in connection with an optical fiber type **R-S-R1.1-(3x0.5)-1200-67°** and an optical frontend type **KL-5-R1.1** are used. At this, the distance of the KL-5-R1.1 to the welding line is approximately 10mm and the spot size at this distance is around 1.7mm x 0.3mm. it should be noted, that the long axis of the white light spot is oriented in parallel to the welding line. Defects of the welding line can be proper detected as shown in the screenshots.

