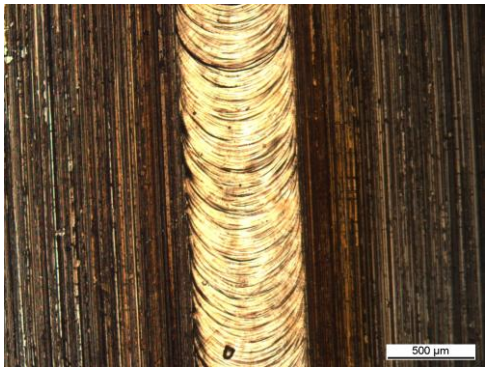
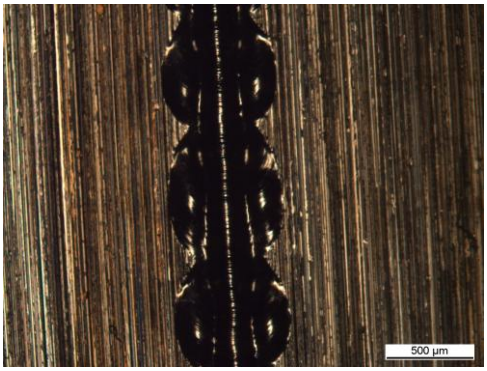
Supplementary Material

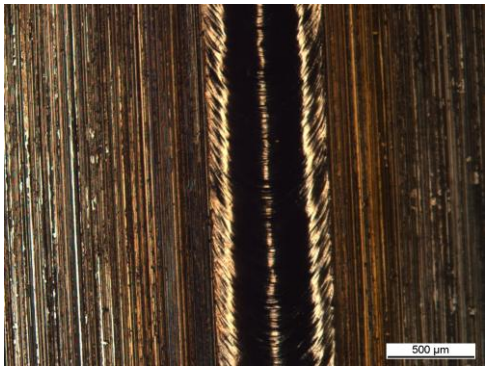
No wobbling



A=200um



A=104um



A=400um

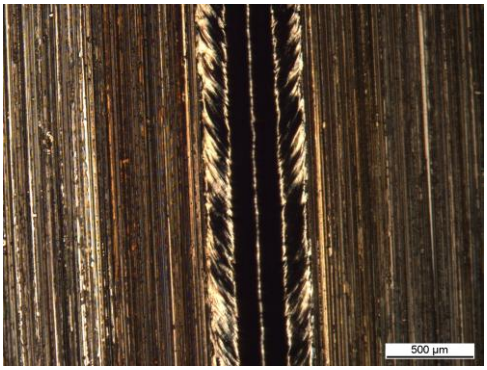


Fig S1: Welding seams produced with pattern1, a power of 100w and a speed of 3mm/s on 220x120x2.15mm plates of 316L steel

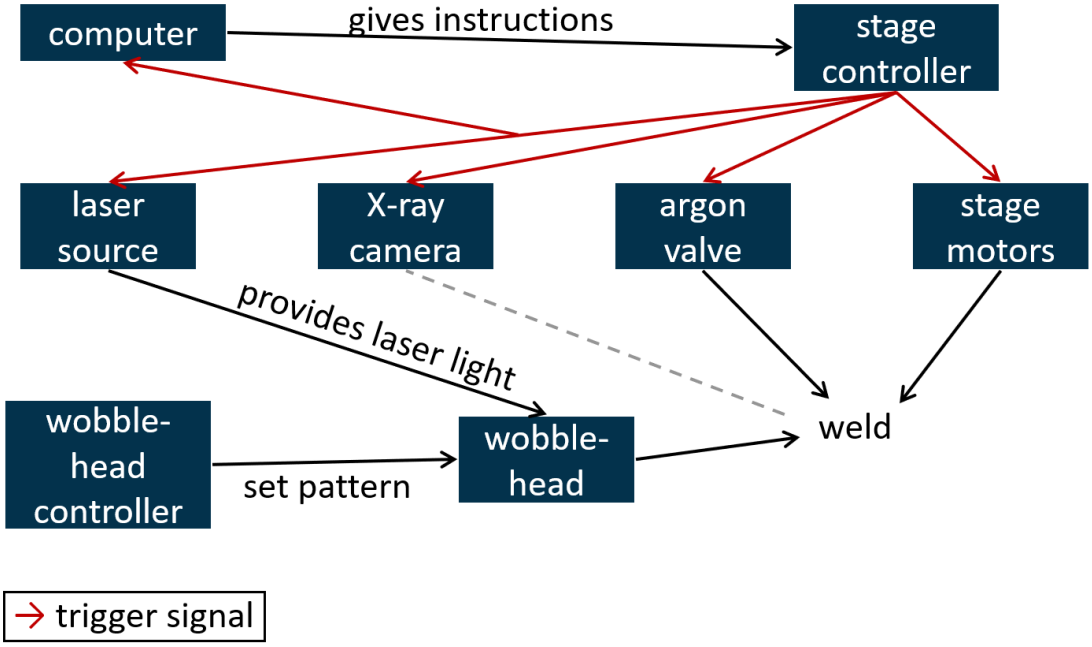


Fig S2: Schematic diagram of the relationship between the different elements used to produce the weld and acquire the X-ray images.