

## Accepted Manuscript

Multi-variable optimisation of the quality characteristics of fiber-laser cladded Inconel-625 composite coatings

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PII: S0257-8972(18)31047-8  
DOI: doi:[10.1016/j.surfcoat.2018.09.063](https://doi.org/10.1016/j.surfcoat.2018.09.063)  
Reference: SCT 23836

To appear in: *Surface & Coatings Technology*

Received date: 18 June 2018  
Revised date: 21 September 2018  
Accepted date: 26 September 2018

Please cite this article as: E.O. Olakanmi, S.T. Nyadongo, K. Malikongwa, S.A. Lawal, A. Botes, L.P. Sisa , Multi-variable optimisation of the quality characteristics of fiber-laser cladded Inconel-625 composite coatings. Sct (2018), doi:[10.1016/j.surfcoat.2018.09.063](https://doi.org/10.1016/j.surfcoat.2018.09.063)

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