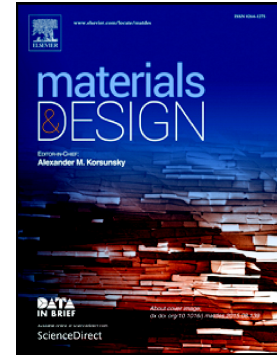


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**Effect of chemical dilution and the number of weld layers on residual stresses  
in a multi-pass low-transformation-temperature weld**

Huai Wang<sup>1,2</sup>, Wanchuck Woo<sup>2\*</sup>, Dong-Kyu Kim<sup>2</sup>, Vyacheslav Em<sup>3</sup>, Soo Yeol Lee<sup>1\*</sup>

<sup>1</sup> *Department of Materials Science and Engineering, Chungnam National University, Daejeon  
34134, South Korea*

<sup>2</sup> *Neutron Science Centre, Korea Atomic Energy Research Institute, Daejeon 34057, South  
Korea*

<sup>3</sup> *Neutron Research Department, NRC Kurchatov Institute, 1 Akademika Kurchatova pl.,  
Moscow, Russia*

\*Corresponding Author

Wanchuck Woo, Ph.D.  
Instrument Scientist  
Neutron Science Center,  
Korea Atomic Energy Research Institute,  
Daejeon, 34057, South Korea  
Phone: 82-42-868-4646  
Fax: 82-42-868-4629  
E-mail: [chuckwoo@kaeri.re.kr](mailto:chuckwoo@kaeri.re.kr)

Soo Yeol Lee, Ph.D.  
Associate Professor  
Materials Science and Engineering,  
Chungnam National University,  
Daejeon, 34134, South Korea  
Phone: 82-42-821-6637  
Fax : 82-42-822-5850  
E-mail: [sylee2012@cnu.ac.kr](mailto:sylee2012@cnu.ac.kr)

\*Author to whom correspondence should be addressed

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