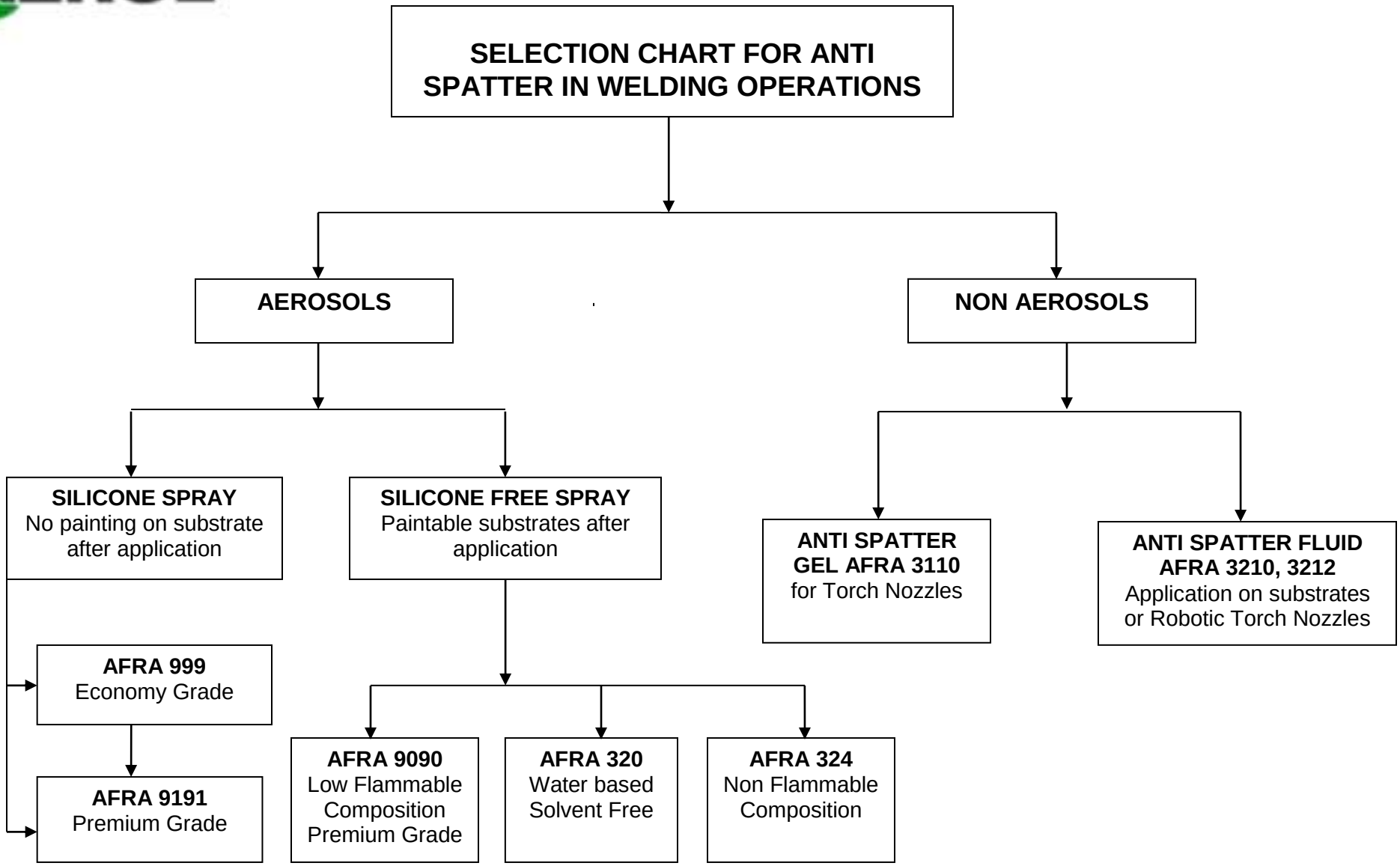SELECTION CHART FOR ANTI SPATTER IN WELDING OPERATIONS