

Table S1

Element	Ti	Al	V	Fe	C	N	H	O	Others
Weight (%)	Remainder	6.10	4.0	0.15	0.03	0.018	0.002	0.13	Each<0.10

Table S2

Sample	Laser Power (kW)	Welding Speed (m/min)
L11	2.6	2.6
L12	2.6	2.8
L13	2.6	3.0
L14	2.7	2.6
L15	2.7	2.8
L16	2.7	3.0
L17	2.8	2.6
L18	2.8	2.8
L19	2.8	3.0