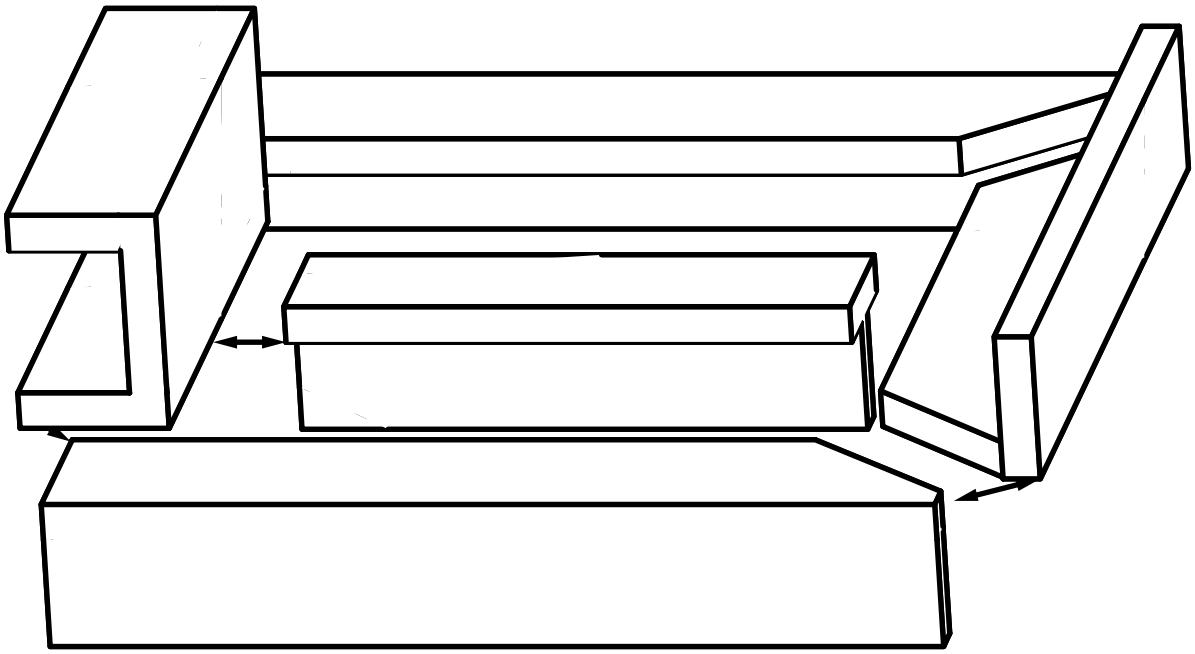Lid Weld Assembly