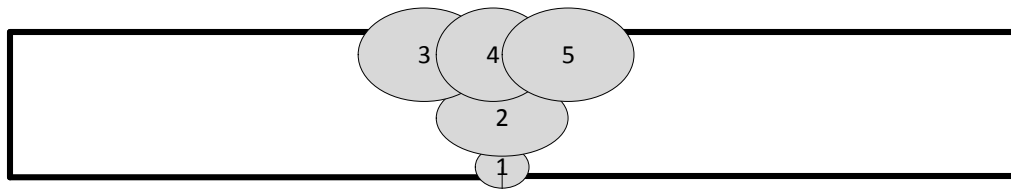
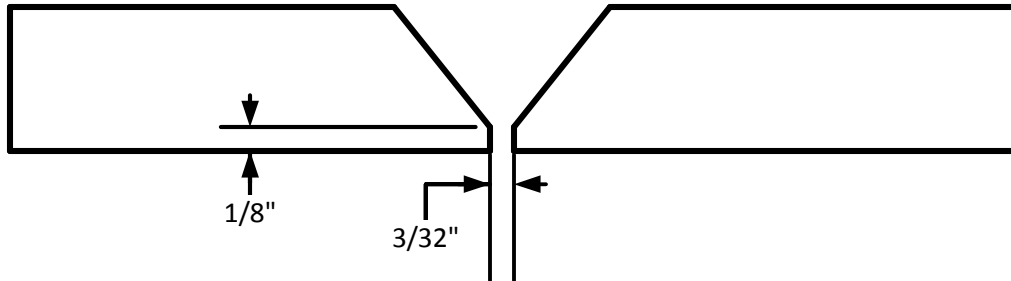


- Prep Plates for a 1G V Groove Butt weld as shown
- Tack weld plates with ½" tacks to hold root gap open
- Use 1/8" E6010 for root of weld (85-90) Amps DC+
- Use 1/8" E7018 for all other passes (125) Amps
- Use 90 deg. Work angle with a 5-10 deg. "drag" Travel angle



Root Pass E6010

"All Passes must be Stringer Beads"

- *Finished weld Must be a Minimum of flush to no more than 1/8" reinforcement*
- *Root shall be 100% Penetration*
- *Two 1 ½" samples will be cut and prepared for the guided bend test*
- *Any observed defect over 1/8" is cause for test failure*