



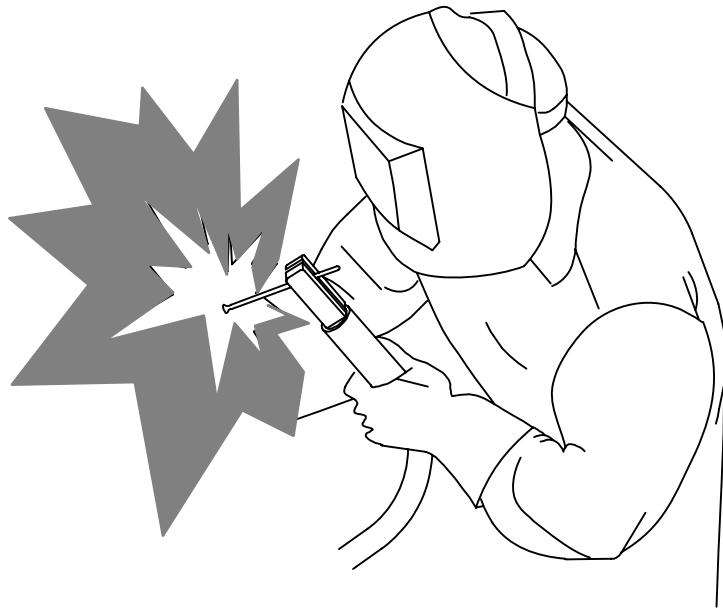
155 095 A

July 2005

Processes



Stick (SMAW) Welding



Guidelines For Shielded Metal Arc Welding (SMAW)



WARNING

ARC WELDING can be hazardous.

This document contains general information about the topics discussed herein. This document is not an application manual and does not contain a complete statement of all factors pertaining to those topics.

This installation, operation, and maintenance of arc welding equipment and the employment of procedures described in this document should be conducted only by qualified persons in accordance with applicable codes, safe practices, and manufacturer's instructions.

Always be certain that work areas are clean and safe and that proper ventilation is used. Misuse of equipment, and failure to observe applicable codes and safe practices, can result in serious personal injury and property damage.



Visit our website at
www.MillerWelds.com

TABLE OF CONTENTS

SECTION 1 – SAFETY PRECAUTIONS - READ BEFORE USING	1
1-1. Symbol Usage	1
1-2. Arc Welding Hazards	1
1-3. Additional Symbols For Installation, Operation, And Maintenance	3
1-4. California Proposition 65 Warnings	3
1-5. Principal Safety Standards	4
1-6. EMF Information	4
SECTION 2 – PRINCIPLES OF SHIELDED METAL ARC WELDING (SMAW)	5
SECTION 3 – SHIELDED METAL ARC WELDING (SMAW) PROCEDURE	6
3-1. Typical Stick Welding Set-Up	6
3-2. Electrode And Amperage Selection Chart	7
3-3. Striking An Arc – Scratch Start Technique	8
3-4. Striking An Arc – Tapping Technique	8
3-5. Positioning Electrode Holder	9
3-6. Electrode Movement During Welding	10
3-7. Conditions That Affect Weld Bead Shape	11
3-8. Poor Weld Bead Characteristics	12
3-9. Good Weld Bead Characteristics	12
3-10. Typical Weld Joints	13
3-11. Welding Butt Joints	14
3-12. Welding Tee Joints	15
3-13. Welding Lap Joints	15
3-14. Welding Horizontal Beads And Butt Joints	16
3-15. Welding Vertical Beads And Butt Joints	17
3-16. Welding Vertical Tee Joints And Lap Joints	18
3-17. Welding Overhead Butt Joints And Tee Joints	19
3-18. Weld Test	20
SECTION 4 – WELDING TROUBLESHOOTING	20
4-1. Porosity	20
4-2. Excessive Spatter	21
4-3. Incomplete Fusion	21
4-4. Lack Of Penetration	21
4-5. Excessive Penetration	22
4-6. Burn-Through	22
4-7. Waviness Of Bead	22
4-8. Distortion	22

SECTION 1 – SAFETY PRECAUTIONS - READ BEFORE USING

som _3/05

▲ **Warning: Protect yourself and others from injury — read and follow these precautions.**

1-1. Symbol Usage



Means Warning! Watch Out! There are possible hazards with this procedure! The possible hazards are shown in the adjoining symbols.

▲ **Marks a special safety message.**

☞ Means "Note"; not safety related.



This group of symbols means Warning! Watch Out! possible ELECTRIC SHOCK, MOVING PARTS, and HOT PARTS hazards. Consult symbols and related instructions below for necessary actions to avoid the hazards.

1-2. Arc Welding Hazards

▲ **The symbols shown below are used throughout this manual to call attention to and identify possible hazards. When you see the symbol, watch out, and follow the related instructions to avoid the hazard. The safety information given below is only a summary of the more complete safety information found in the Safety Standards listed in Section 1-5. Read and follow all Safety Standards.**

▲ **Only qualified persons should install, operate, maintain, and repair this unit.**

▲ **During operation, keep everybody, especially children, away.**



ELECTRIC SHOCK can kill.

Touching live electrical parts can cause fatal shocks or severe burns. The electrode and work circuit is electrically live whenever the output is on. The input power circuit and machine internal circuits are also

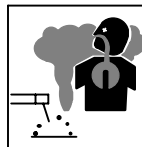
live when power is on. In semiautomatic or automatic wire welding, the wire, wire reel, drive roll housing, and all metal parts touching the welding wire are electrically live. Incorrectly installed or improperly grounded equipment is a hazard.

- Do not touch live electrical parts.
- Wear dry, hole-free insulating gloves and body protection.
- Insulate yourself from work and ground using dry insulating mats or covers big enough to prevent any physical contact with the work or ground.
- Do not use AC output in damp areas, if movement is confined, or if there is a danger of falling.
- Use AC output ONLY if required for the welding process.
- If AC output is required, use remote output control if present on unit.
- Additional safety precautions are required when any of the following electrically hazardous conditions are present: in damp locations or while wearing wet clothing; on metal structures such as floors, gratings, or scaffolds; when in cramped positions such as sitting, kneeling, or lying; or when there is a high risk of unavoidable or accidental contact with the workpiece or ground. For these conditions, use the following equipment in order presented: 1) a semiautomatic DC constant voltage (wire) welder, 2) a DC manual (stick) welder, or 3) an AC welder with reduced open-circuit voltage. In most situations, use of a DC, constant voltage wire welder is recommended. And, do not work alone!
- Disconnect input power or stop engine before installing or servicing this equipment. Lockout/tagout input power according to OSHA 29 CFR 1910.147 (see Safety Standards).
- Properly install and ground this equipment according to its Owner's Manual and national, state, and local codes.
- Always verify the supply ground – check and be sure that input power cord ground wire is properly connected to ground terminal in disconnect box or that cord plug is connected to a properly grounded receptacle outlet.
- When making input connections, attach proper grounding conductor first – double-check connections.
- Frequently inspect input power cord for damage or bare wiring – replace cord immediately if damaged – bare wiring can kill.

- Turn off all equipment when not in use.
- Do not use worn, damaged, undersized, or poorly spliced cables.
- Do not drape cables over your body.
- If earth grounding of the workpiece is required, ground it directly with a separate cable.
- Do not touch electrode if you are in contact with the work, ground, or another electrode from a different machine.
- Do not touch electrode holders connected to two welding machines at the same time since double open-circuit voltage will be present.
- Use only well-maintained equipment. Repair or replace damaged parts at once. Maintain unit according to manual.
- Wear a safety harness if working above floor level.
- Keep all panels and covers securely in place.
- Clamp work cable with good metal-to-metal contact to workpiece or worktable as near the weld as practical.
- Insulate work clamp when not connected to workpiece to prevent contact with any metal object.
- Do not connect more than one electrode or work cable to any single weld output terminal.

SIGNIFICANT DC VOLTAGE exists in inverter-type welding power sources after removal of input power.

- Turn Off inverter, disconnect input power, and discharge input capacitors according to instructions in Maintenance Section before touching any parts.



FUMES AND GASES can be hazardous.

Welding produces fumes and gases. Breathing these fumes and gases can be hazardous to your health.

- Keep your head out of the fumes. Do not breathe the fumes.
- If inside, ventilate the area and/or use local forced ventilation at the arc to remove welding fumes and gases.
- If ventilation is poor, wear an approved air-supplied respirator.
- Read and understand the Material Safety Data Sheets (MSDSs) and the manufacturer's instructions for metals, consumables, coatings, cleaners, and degreasers.
- Work in a confined space only if it is well ventilated, or while wearing an air-supplied respirator. Always have a trained watch-person nearby. Welding fumes and gases can displace air and lower the oxygen level causing injury or death. Be sure the breathing air is safe.
- Do not weld in locations near degreasing, cleaning, or spraying operations. The heat and rays of the arc can react with vapors to form highly toxic and irritating gases.
- Do not weld on coated metals, such as galvanized, lead, or cadmium plated steel, unless the coating is removed from the weld area, the area is well ventilated, and while wearing an air-supplied respirator. The coatings and any metals containing these elements can give off toxic fumes if welded.



ARC RAYS can burn eyes and skin.

Arc rays from the welding process produce intense visible and invisible (ultraviolet and infrared) rays that can burn eyes and skin. Sparks fly off from the weld.

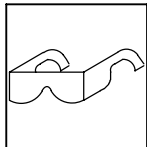
- Wear an approved welding helmet fitted with a proper shade of filter lenses to protect your face and eyes when welding or watching (see ANSI Z49.1 and Z87.1 listed in Safety Standards).
- Wear approved safety glasses with side shields under your helmet.
- Use protective screens or barriers to protect others from flash, glare and sparks; warn others not to watch the arc.
- Wear protective clothing made from durable, flame-resistant material (leather, heavy cotton, or wool) and foot protection.



WELDING can cause fire or explosion.

Welding on closed containers, such as tanks, drums, or pipes, can cause them to blow up. Sparks can fly off from the welding arc. The flying sparks, hot workpiece, and hot equipment can cause fires and burns. Accidental contact of electrode to metal objects can cause sparks, explosion, overheating, or fire. Check and be sure the area is safe before doing any welding.

- Remove all flammables within 35 ft (10.7 m) of the welding arc. If this is not possible, tightly cover them with approved covers.
- Do not weld where flying sparks can strike flammable material.
- Protect yourself and others from flying sparks and hot metal.
- Be alert that welding sparks and hot materials from welding can easily go through small cracks and openings to adjacent areas.
- Watch for fire, and keep a fire extinguisher nearby.
- Be aware that welding on a ceiling, floor, bulkhead, or partition can cause fire on the hidden side.
- Do not weld on closed containers such as tanks, drums, or pipes, unless they are properly prepared according to AWS F4.1 (see Safety Standards).
- Connect work cable to the work as close to the welding area as practical to prevent welding current from traveling long, possibly unknown paths and causing electric shock, sparks, and fire hazards.
- Do not use welder to thaw frozen pipes.
- Remove stick electrode from holder or cut off welding wire at contact tip when not in use.
- Wear oil-free protective garments such as leather gloves, heavy shirt, cuffless trousers, high shoes, and a cap.
- Remove any combustibles, such as a butane lighter or matches, from your person before doing any welding.
- Follow requirements in OSHA 1910.252 (a) (2) (iv) and NFPA 51B for hot work and have a fire watcher and extinguisher nearby.



FLYING METAL can injure eyes.

- Welding, chipping, wire brushing, and grinding cause sparks and flying metal. As welds cool, they can throw off slag.
- Wear approved safety glasses with side shields even under your welding helmet.



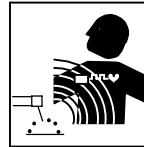
BUILDUP OF GAS can injure or kill.

- Shut off shielding gas supply when not in use.
- Always ventilate confined spaces or use approved air-supplied respirator.



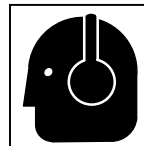
HOT PARTS can cause severe burns.

- Do not touch hot parts bare handed.
- Allow cooling period before working on gun or torch.
- To handle hot parts, use proper tools and/or wear heavy, insulated welding gloves and clothing to prevent burns.



MAGNETIC FIELDS can affect pacemakers.

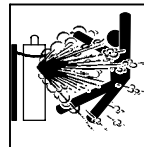
- Pacemaker wearers keep away.
- Wearers should consult their doctor before going near arc welding, gouging, or spot welding operations.



NOISE can damage hearing.

Noise from some processes or equipment can damage hearing.

- Wear approved ear protection if noise level is high.



CYLINDERS can explode if damaged.

Shielding gas cylinders contain gas under high pressure. If damaged, a cylinder can explode. Since gas cylinders are normally part of the welding process, be sure to treat them carefully.

- Protect compressed gas cylinders from excessive heat, mechanical shocks, physical damage, slag, open flames, sparks, and arcs.
- Install cylinders in an upright position by securing to a stationary support or cylinder rack to prevent falling or tipping.
- Keep cylinders away from any welding or other electrical circuits.
- Never drape a welding torch over a gas cylinder.
- Never allow a welding electrode to touch any cylinder.
- Never weld on a pressurized cylinder – explosion will result.
- Use only correct shielding gas cylinders, regulators, hoses, and fittings designed for the specific application; maintain them and associated parts in good condition.
- Turn face away from valve outlet when opening cylinder valve.
- Keep protective cap in place over valve except when cylinder is in use or connected for use.
- Use the right equipment, correct procedures, and sufficient number of persons to lift and move cylinders.
- Read and follow instructions on compressed gas cylinders, associated equipment, and Compressed Gas Association (CGA) publication P-1 listed in Safety Standards.

1-3. Additional Symbols For Installation, Operation, And Maintenance



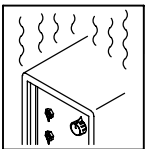
FIRE OR EXPLOSION hazard.

- Do not install or place unit on, over, or near combustible surfaces.
- Do not install unit near flammables.
- Do not overload building wiring – be sure power supply system is properly sized, rated, and protected to handle this unit.



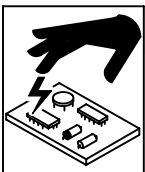
FALLING UNIT can cause injury.

- Use lifting eye to lift unit only, NOT running gear, gas cylinders, or any other accessories.
- Use equipment of adequate capacity to lift and support unit.
- If using lift forks to move unit, be sure forks are long enough to extend beyond opposite side of unit.



OVERUSE can cause OVERHEATING

- Allow cooling period; follow rated duty cycle.
- Reduce current or reduce duty cycle before starting to weld again.
- Do not block or filter airflow to unit.



STATIC (ESD) can damage PC boards.

- Put on grounded wrist strap BEFORE handling boards or parts.
- Use proper static-proof bags and boxes to store, move, or ship PC boards.



MOVING PARTS can cause injury.

- Keep away from moving parts.
- Keep away from pinch points such as drive rolls.



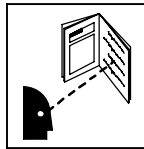
WELDING WIRE can cause injury.

- Do not press gun trigger until instructed to do so.
- Do not point gun toward any part of the body, other people, or any metal when threading welding wire.



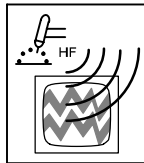
MOVING PARTS can cause injury.

- Keep away from moving parts such as fans.
- Keep all doors, panels, covers, and guards closed and securely in place.
- Have only qualified persons remove doors, panels, covers, or guards for maintenance as necessary.
- Reinstall doors, panels, covers, or guards when maintenance is finished and before re-connecting input power.



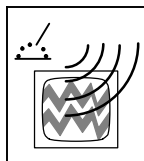
READ INSTRUCTIONS.

- Read Owner's Manual before using or servicing unit.
- Use only genuine Miller/Hobart replacement parts.



H.F. RADIATION can cause interference.

- High-frequency (H.F.) can interfere with radio navigation, safety services, computers, and communications equipment.
- Have only qualified persons familiar with electronic equipment perform this installation.
- The user is responsible for having a qualified electrician promptly correct any interference problem resulting from the installation.
- If notified by the FCC about interference, stop using the equipment at once.
- Have the installation regularly checked and maintained.
- Keep high-frequency source doors and panels tightly shut, keep spark gaps at correct setting, and use grounding and shielding to minimize the possibility of interference.



ARC WELDING can cause interference.

- Electromagnetic energy can interfere with sensitive electronic equipment such as computers and computer-driven equipment such as robots.
- Be sure all equipment in the welding area is electromagnetically compatible.
- To reduce possible interference, keep weld cables as short as possible, close together, and down low, such as on the floor.
- Locate welding operation 100 meters from any sensitive electronic equipment.
- Be sure this welding machine is installed and grounded according to this manual.
- If interference still occurs, the user must take extra measures such as moving the welding machine, using shielded cables, using line filters, or shielding the work area.

1-4. California Proposition 65 Warnings

- ▲ **Welding or cutting equipment produces fumes or gases which contain chemicals known to the State of California to cause birth defects and, in some cases, cancer. (California Health & Safety Code Section 25249.5 et seq.)**
- ▲ **Battery posts, terminals and related accessories contain lead and lead compounds, chemicals known to the State of California to cause cancer and birth defects or other reproductive harm. Wash hands after handling.**

For Gasoline Engines:

- ▲ **Engine exhaust contains chemicals known to the State of California to cause cancer, birth defects, or other reproductive harm.**

For Diesel Engines:

- ▲ **Diesel engine exhaust and some of its constituents are known to the State of California to cause cancer, birth defects, and other reproductive harm.**

1-5. Principal Safety Standards

Safety in Welding, Cutting, and Allied Processes, ANSI Standard Z49.1, from Global Engineering Documents (phone: 1-877-413-5184, website: www.global.ihs.com).

Recommended Safe Practices for the Preparation for Welding and Cutting of Containers and Piping, American Welding Society Standard AWS F4.1 from Global Engineering Documents (phone: 1-877-413-5184, website: www.global.ihs.com).

National Electrical Code, NFPA Standard 70, from National Fire Protection Association, P.O. Box 9101, 1 Battery March Park, Quincy, MA 02269-9101 (phone: 617-770-3000, website: www.nfpa.org).

Safe Handling of Compressed Gases in Cylinders, CGA Pamphlet P-1, from Compressed Gas Association, 1735 Jefferson Davis Highway, Suite 1004, Arlington, VA 22202-4102 (phone: 703-412-0900, website: www.cganet.com).

Code for Safety in Welding and Cutting, CSA Standard W117.2, from Canadian Standards Association, Standards Sales, 178 Rexdale

Boulevard, Rexdale, Ontario, Canada M9W 1R3 (phone: 800-463-6727 or in Toronto 416-747-4044, website: www.csa-international.org).

Practice For Occupational And Educational Eye And Face Protection, ANSI Standard Z87.1, from American National Standards Institute, 11 West 42nd Street, New York, NY 10036-8002 (phone: 212-642-4900, website: www.ansi.org).

Standard for Fire Prevention During Welding, Cutting, and Other Hot Work, NFPA Standard 51B, from National Fire Protection Association, P.O. Box 9101, 1 Battery March Park, Quincy, MA 02269-9101 (phone: 617-770-3000, website: www.nfpa.org).

OSHA, Occupational Safety and Health Standards for General Industry, Title 29, Code of Federal Regulations (CFR), Part 1910, Subpart Q, and Part 1926, Subpart J, from U.S. Government Printing Office, Superintendent of Documents, P.O. Box 371954, Pittsburgh, PA 15250 (there are 10 Regional Offices—phone for Region 5, Chicago, is 312-353-2220, website: www.osha.gov).

1-6. EMF Information

Considerations About Welding And The Effects Of Low Frequency Electric And Magnetic Fields

Welding current, as it flows through welding cables, will cause electromagnetic fields. There has been and still is some concern about such fields. However, after examining more than 500 studies spanning 17 years of research, a special blue ribbon committee of the National Research Council concluded that: "The body of evidence, in the committee's judgment, has not demonstrated that exposure to power-frequency electric and magnetic fields is a human-health hazard." However, studies are still going forth and evidence continues to be examined. Until the final conclusions of the research are reached, you may wish to minimize your exposure to electromagnetic fields when welding or cutting.

To reduce magnetic fields in the workplace, use the following procedures:

1. Keep cables close together by twisting or taping them.
2. Arrange cables to one side and away from the operator.
3. Do not coil or drape cables around your body.
4. Keep welding power source and cables as far away from operator as practical.
5. Connect work clamp to workpiece as close to the weld as possible.

About Pacemakers:

Pacemaker wearers consult your doctor before welding or going near welding operations. If cleared by your doctor, then following the above procedures is recommended.

SECTION 2 – PRINCIPLES OF SHIELDED METAL ARC WELDING (SMAW)

Shielded Metal Arc Welding (SMAW) or Stick welding is a process which melts and joins metals by heating them with an arc between a coated metal electrode and the workpiece. The electrode outer coating, called flux, assists in creating the arc and provides the shielding gas and slag covering to protect the weld from contamination. The electrode core provides most of the weld filler metal.

When the electrode is moved along the workpiece at the correct speed the metal deposits in a uniform layer called a bead.

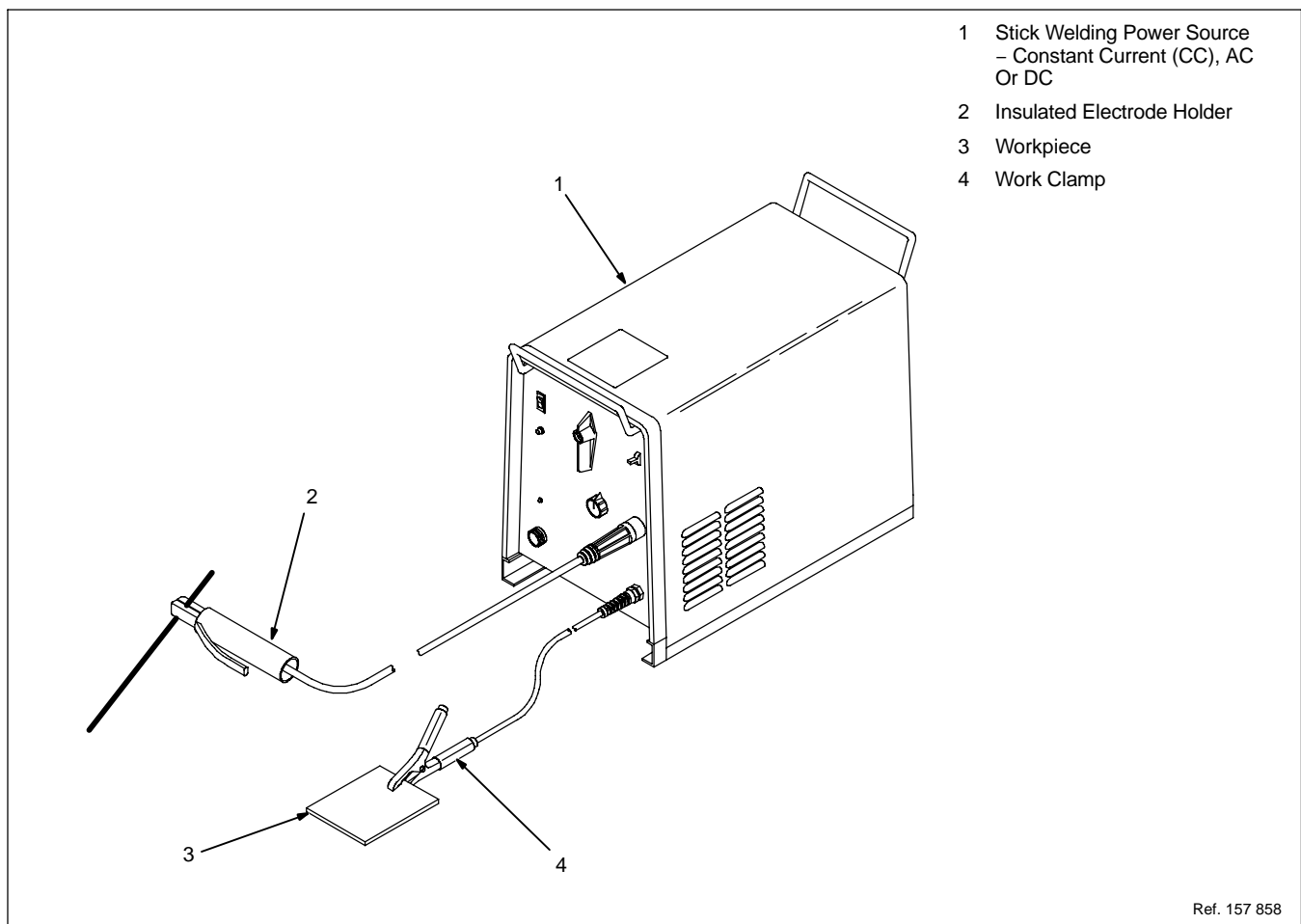
The Stick welding power source provides constant current (CC) and may be either alternating current (AC) or direct current (DC), depending on the electrode being used. The best welding characteristics are usually obtained using DC power sources.

The power in a welding circuit is measured in voltage and current. The voltage (Volts) is governed by the arc length between the electrode and the workpiece and is influenced by electrode diameter. Current is a more practical measure of the power in a weld circuit and is measured in amperes (Amps).

The amperage needed to weld depends on electrode diameter, the size and thickness of the pieces to be welded, and the position of the welding. Generally, a smaller electrode and lower amperage is needed to weld a small piece than a large piece of the same thickness. Thin metals require less current than thick metals, and a small electrode requires less amperage than a large one.

It is preferable to weld on work in the flat or horizontal position. However, when forced to weld in vertical or overhead positions it is helpful to reduce the amperage from that used when welding horizontally. Best welding results are achieved by maintaining a short arc, moving the electrode at a uniform speed, and feeding the electrode downward at a constant speed as it melts.

More specific information on the Stick welding procedure is provided in the following sections.



SECTION 3 – SHIELDED METAL ARC WELDING (SMAW) PROCEDURE

3-1. Typical Stick Welding Set-Up

▲ Welding current starts as soon as electrode touches the workpiece.

- 1 Workpiece
Make sure workpiece is clean before welding.
- 2 Work Clamp
Place as close to the weld as possible.
- 3 Electrode
Before striking an arc, insert an electrode in the electrode holder. A small diameter electrode requires less current than a large one. Follow recommendations of the electrode manufacturer when setting weld amperage (see Section 3-2).
- 4 Insulated Electrode Holder
- 5 Electrode Holder Position
- 6 Arc Length
Arc length is the distance from the electrode to the workpiece. A short arc with correct amperage will give a sharp, crackling sound. Correct arc length is related to electrode diameter. Examine the weld bead to determine if the arc length is correct.
Arc length for 1/16 and 3/32 in diameter electrodes should be about 1/16 in (1.6 mm); arc length for 1/8 and 5/32 in electrodes should be about 1/8 in (3 mm).
- 7 Slag
Use a chipping hammer and wire brush to remove slag. Remove slag and check weld bead before making another weld pass.

Tools Needed:

151 593

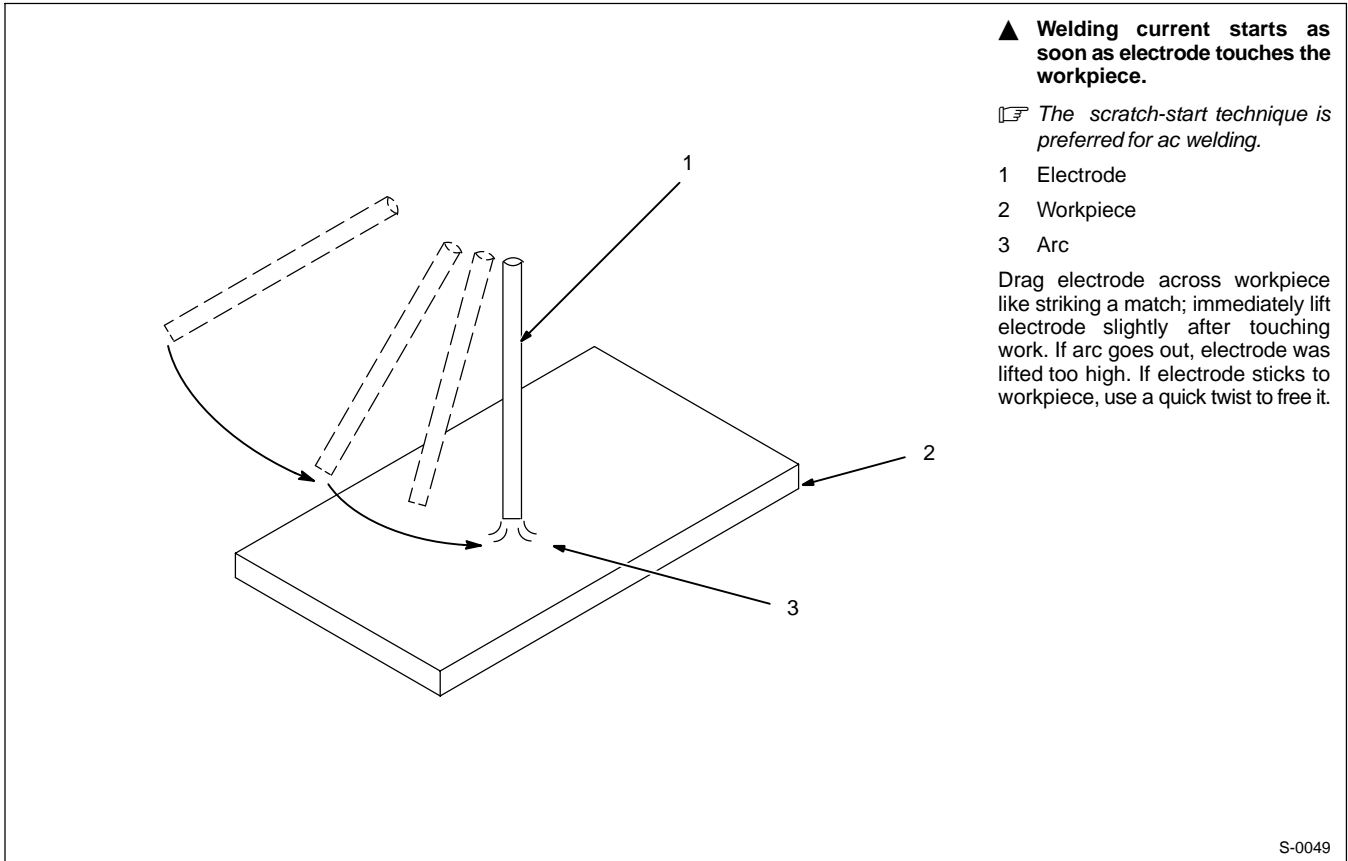
3-2. Electrode And Amperage Selection Chart

ELECTRODE	DIAMETER	AMPERAGE RANGE									
		50	100	150	200	250	300	350	400	450	
6010 & 6011	3/32	■	■								
	1/8		■	■							
	5/32			■	■						
	3/16				■	■					
	7/32					■	■				
6013	1/4	■	■								
	1/16	■	■								
	5/64		■	■							
	3/32			■	■						
	1/8				■	■					
	5/32					■	■				
	3/16						■	■			
	7/32							■	■		
7014	1/4								■	■	
	3/32									■	■
	1/8										■
	5/32										
	3/16										
	7/32										
7018	1/4										
	3/32										
	1/8										
	5/32										
	3/16										
	7/32										
7024	1/4										
	3/32										
	1/8										
	5/32										
	3/16										
	7/32										
Ni-Cl	1/4										
	3/32										
	1/8										
	5/32										
308L	3/16										
	3/32										
	1/8										
	5/32										

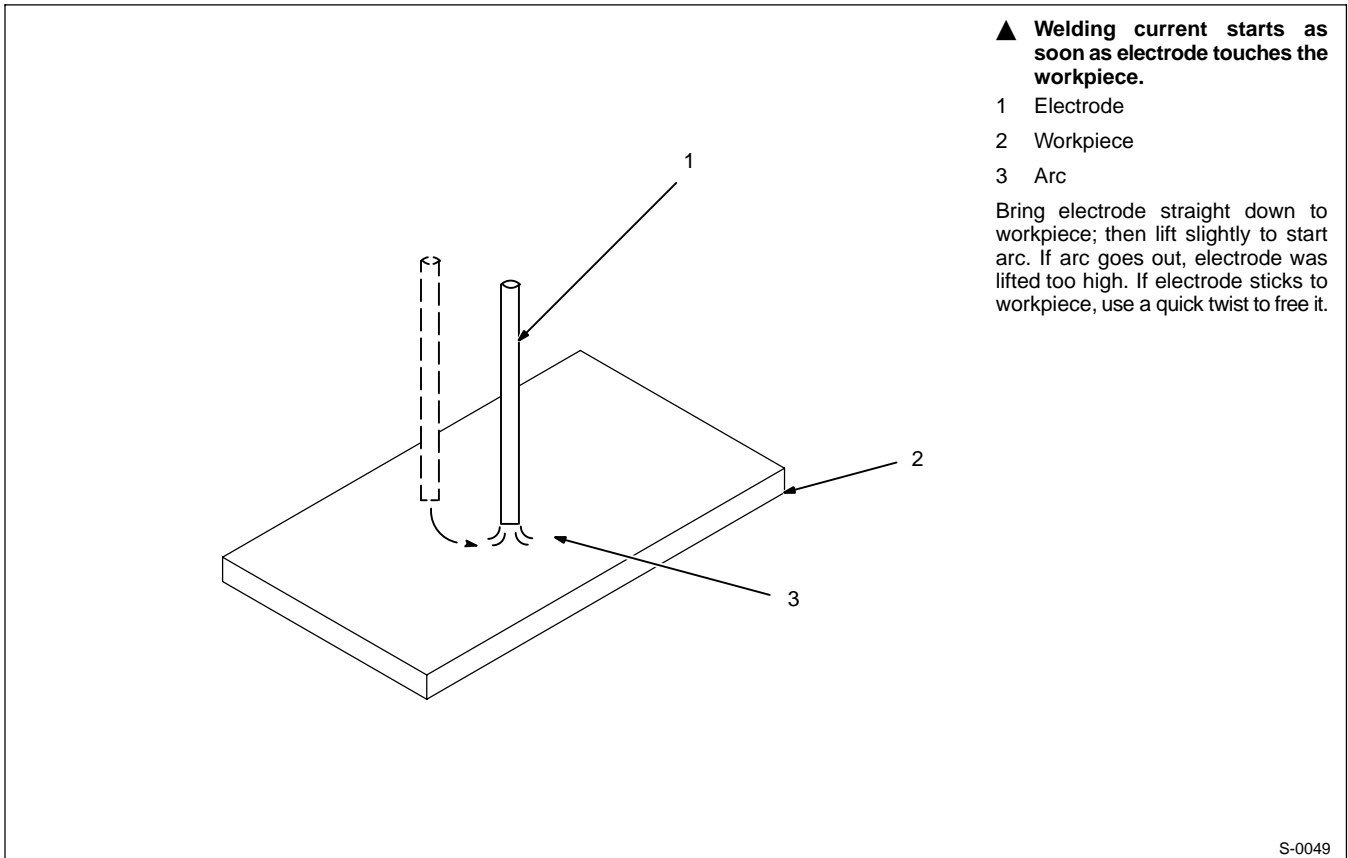
ELECTRODE	DC*	AC	POSITION	PENETRATION	USAGE
6010	EP		ALL	DEEP	MIN. PREP, ROUGH HIGH SPATTER
6011	EP	✓	ALL	DEEP	
6013	EP,EN	✓	ALL	LOW	GENERAL
7014	EP,EN	✓	ALL	MED	SMOOTH, EASY, FAST
7018	EP	✓	ALL	LOW	LOW HYDROGEN, STRONG
7024	EP,EN	✓	FLAT HORIZ FILLET	LOW	SMOOTH, EASY, FASTER
NI-CL	EP	✓	ALL	LOW	CAST IRON
308L	EP	✓	ALL	LOW	STAINLESS

*EP = ELECTRODE POSITIVE (REVERSE POLARITY)
EN = ELECTRODE NEGATIVE (STRAIGHT POLARITY)

3-3. Striking An Arc – Scratch Start Technique

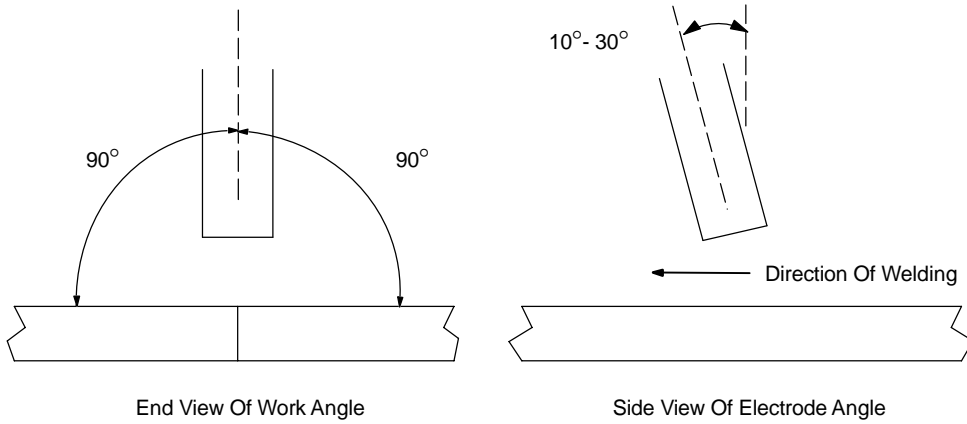


3-4. Striking An Arc – Tapping Technique



3-5. Positioning Electrode Holder

Groove Welds

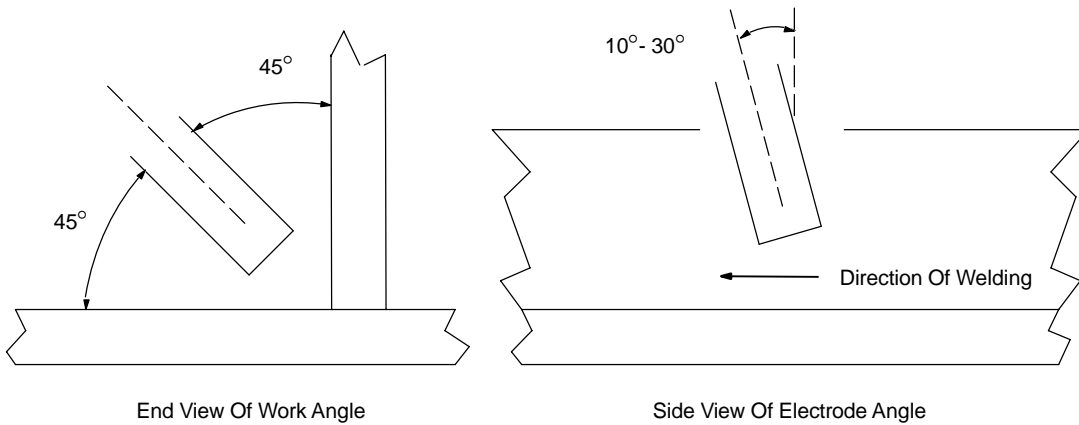


After learning to start and hold an arc, practice running beads of weld metal on flat plates using a full electrode.

Hold the electrode nearly perpendicular to the work, although tilting it ahead (in the direction of travel) will be helpful.

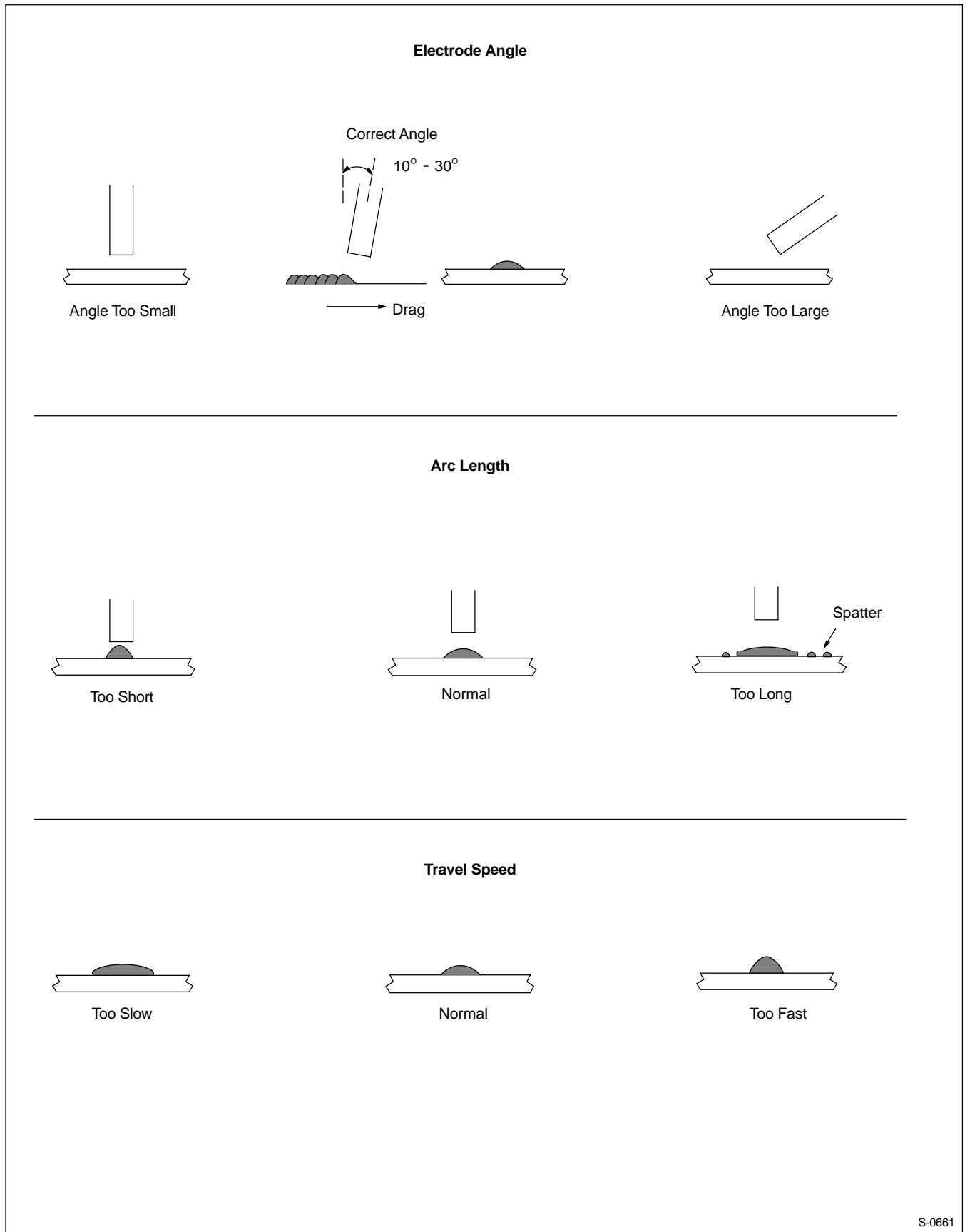
To produce the best results, hold a short arc, travel at a uniform speed, and feed the electrode downward at a constant rate as it melts.

Fillet Welds



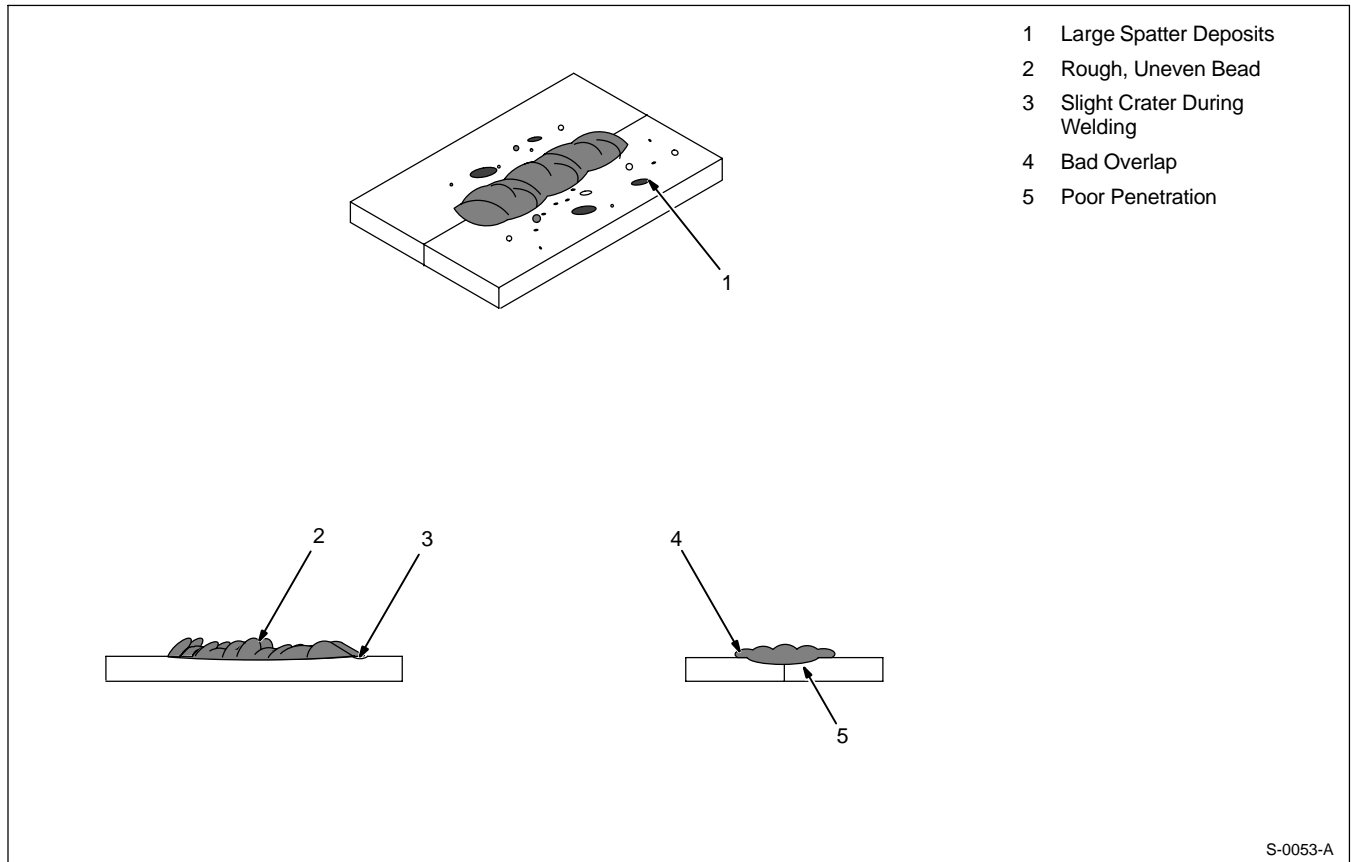
3-7. Conditions That Affect Weld Bead Shape

► **IMPORTANT:** *Weld bead shape is affected by electrode angle, arc length, travel speed, and thickness of base metal.*

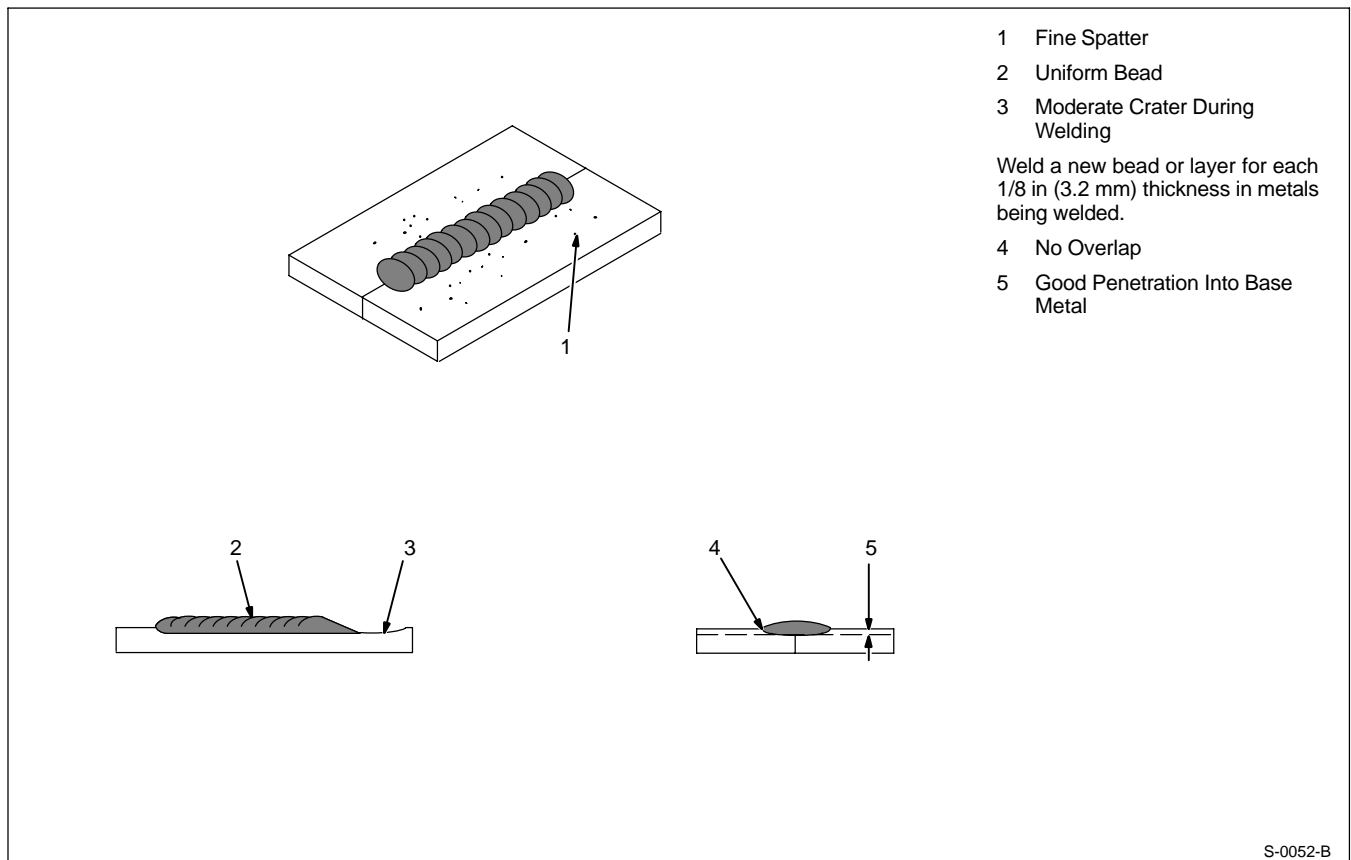


S-0661

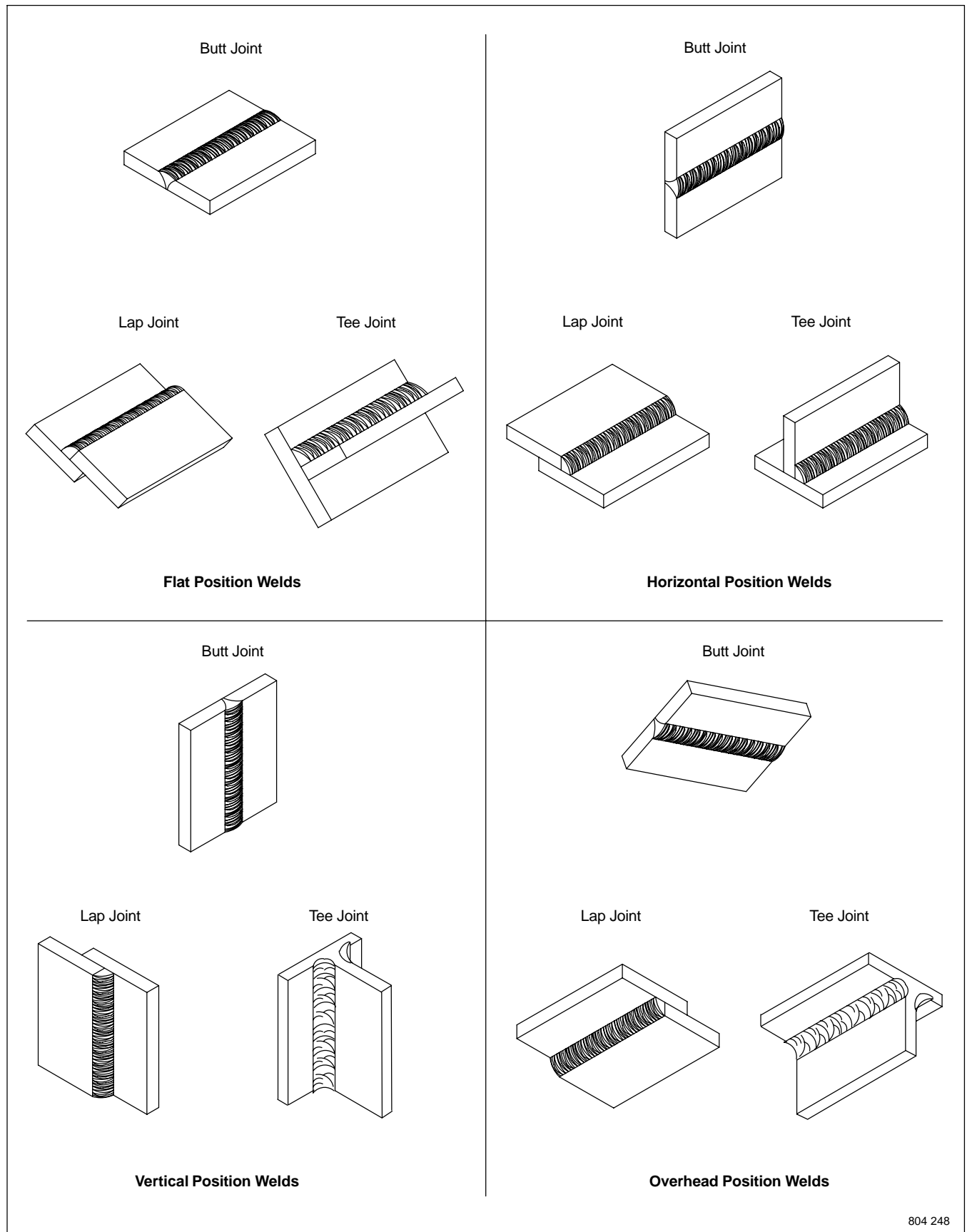
3-8. Poor Weld Bead Characteristics



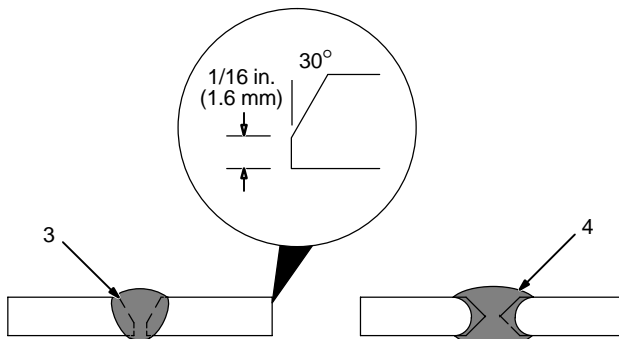
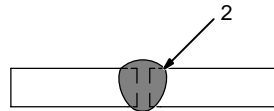
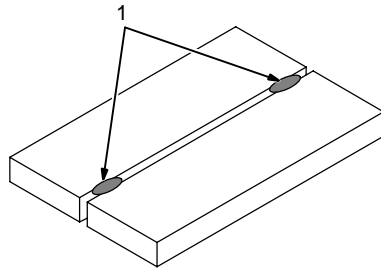
3-9. Good Weld Bead Characteristics



3-10. Typical Weld Joints



3-11. Welding Butt Joints



Types Of Butt Joint Welds

1 Tack Welds

Prevent butt joint distortion by tack welding the materials in position before final weld.

Workpiece distortion occurs when heat is applied locally to a joint. One side of a metal plate will “curl” up toward the weld. Distortion will also cause the edges of a butt joint to pull together ahead of the electrode as the weld cools.

2 Square Groove Weld

3 Single V-Groove Weld

4 Double V-Groove Weld

Materials up to 3/16 in (5 mm) thick can often be welded without special preparation using the square groove weld. However, when welding thicker materials it may be necessary to prepare the edges (V-groove) of butt joints to ensure good welds.

The single or double V-groove weld is good for materials 3/16 – 3/4 in (5-19 mm) thick. Generally, the single V-groove is used on materials up to 3/4 in (19 mm) thick and when, regardless of thickness, you can weld from one side only. Cut the bevel with oxyacetylene or plasma cutting equipment. Remove scale from material after cutting. A grinder can also be used to prepare bevels.

Create a 30 degree angle of bevel on materials in V-groove welding.

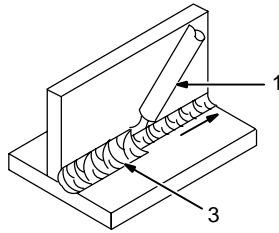
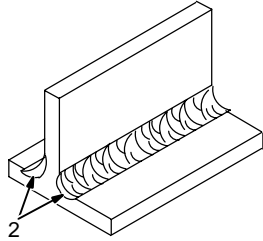
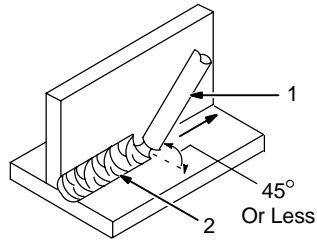
Butt Joint Training Procedure

Practice welding butt joints on 1/8 in (4 mm) or thicker material. (Avoid thinner materials since they require greater skill.) Separate the squared edges of the material about 1/16 in (1.6 mm) and make a butt weld all the way through with a 1/8 in electrode. (You may need to adjust the weld current and travel speed to obtain the desired weld.) Perform a similar exercise on 1/4 in (6 mm) material, depositing a bead on each side of the joint and fusing one to the another (no bevel needed).

Practice making a single V-groove weld on 1/4 in (6 mm) plate beveled 30°. Start with a 1/8 in electrode for the first bead and finish with a 5/32 in (4 mm) electrode. Be sure to penetrate about 1/32 in (1 mm) beyond the bottom of the “V” or root. Perform a similar exercise on thicker materials. Generally, deposit a bead for each 1/8 in (3mm) of material thickness, cleaning the joint between layers. On heavier plates, it may be necessary to weave the top layers to fill the groove.

After completing the practice welds, test them as described in Section 3-18.

3-12. Welding Tee Joints



- 1 Electrode
- 2 Fillet Weld

Keep arc short and move at definite rate of speed. Hold electrode as shown to provide fusion into the corner. Square edge of the weld surface.

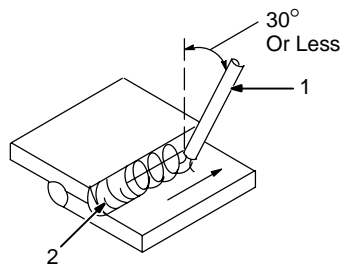
For maximum strength weld both sides of upright section.

- 3 Multi-Layer Deposits

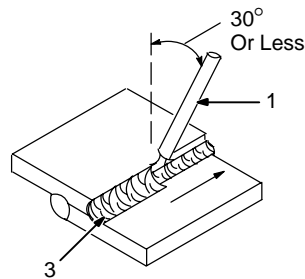
Weld a second layer when a heavier fillet is needed. Use any of the weaving patterns shown in Section 3-6. Remove slag before making another weld pass.

S-0060 / S-0058-A / S-0061

3-13. Welding Lap Joints



Single-Layer Fillet Weld



Multi-Layer Fillet Weld

- 1 Electrode
- 2 Single-Layer Fillet Weld

Move electrode in circular motion.

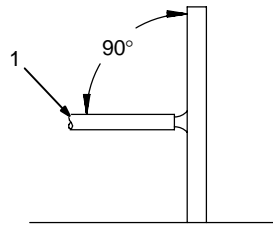
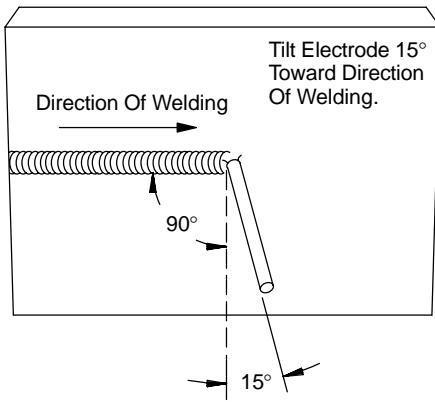
- 3 Multi-Layer Fillet Weld

Weld a second layer when a heavier fillet is needed. Remove slag before making another weld pass. Weld both sides of joint for maximum strength.

S-0063 / S-0064

3-14. Welding Horizontal Beads And Butt Joints

Single Pass Bead Weld



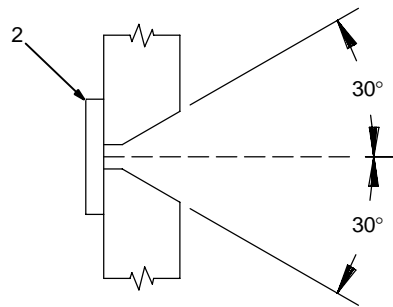
☞ When welding horizontally, gravity may distort the molten metal.

☞ This technique is not suitable for all electrodes.

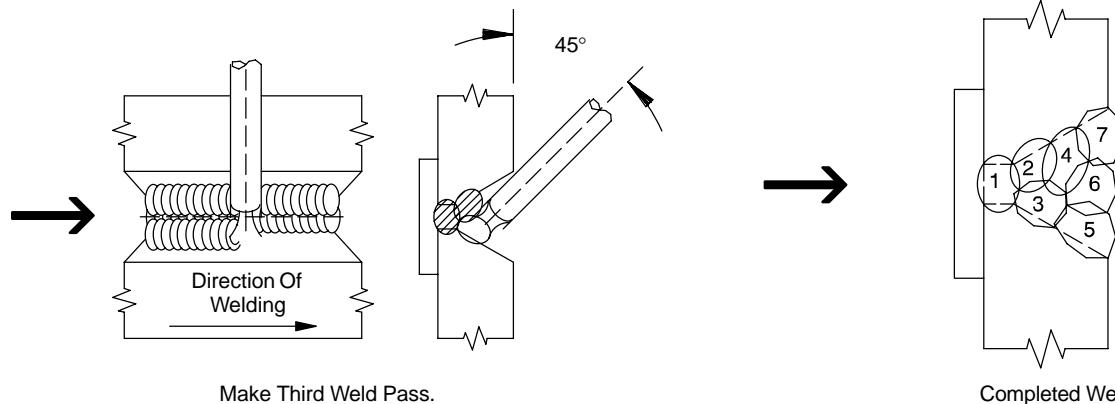
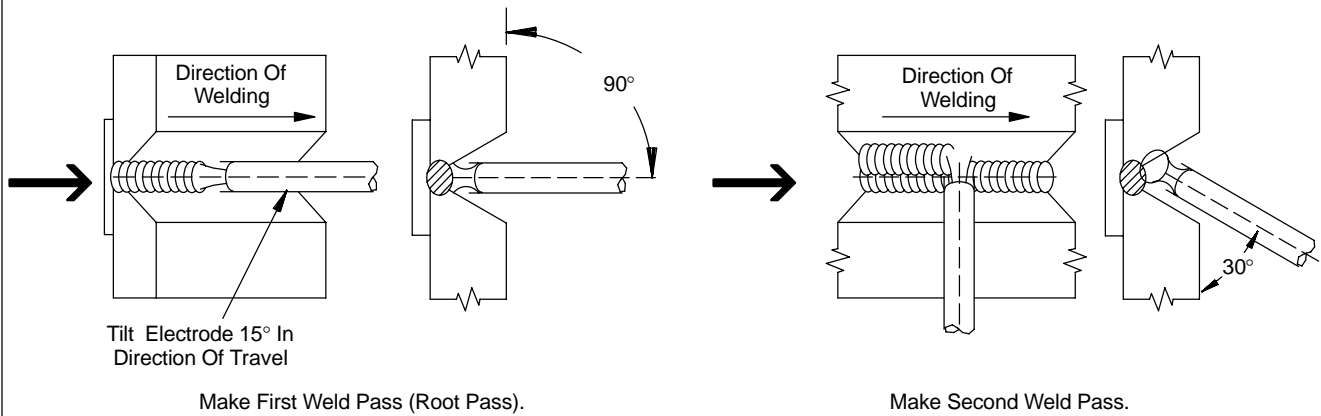
- 1 Electrode
- 2 Backing Strip

Bevel edges if warranted by material thickness (see Section 3-11). Tack weld a backing strip to the plates to make the first weld pass (root pass) easier.

Single Pass Horizontal Butt Joint Weld Or First Pass Of Multi-Layer Deposit

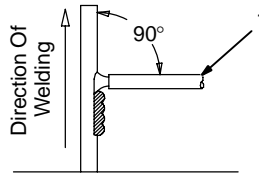
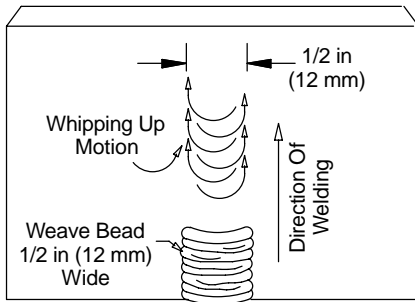


Bevel Material If Necessary (See Section 3-11).



3-15. Welding Vertical Beads And Butt Joints

Single Pass Bead Weld



☞ When welding vertically, gravity may distort the molten metal.

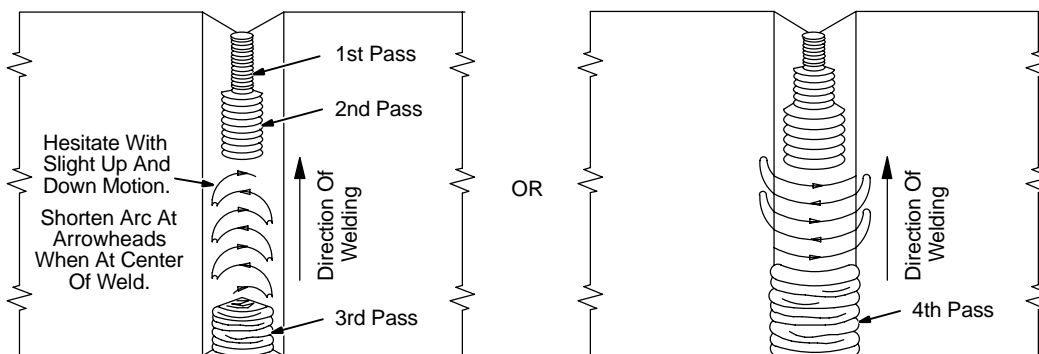
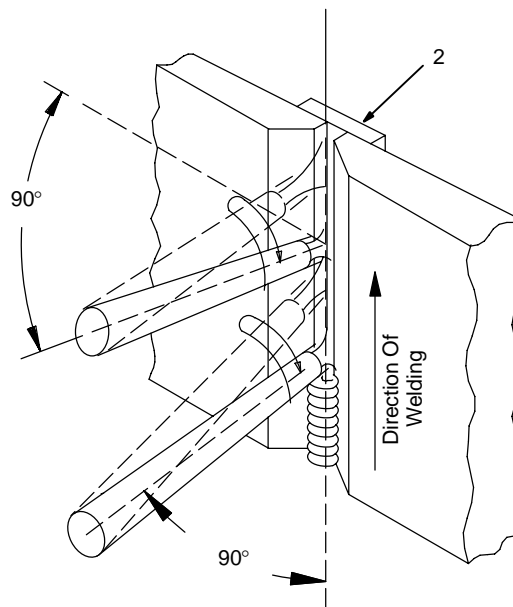
☞ This technique is not suitable for all electrodes.

- 1 Electrode
- 2 Backing Strip

Weld vertically by carrying the weld upward or starting at the top and welding down. Welding upward is easier and is shown in these illustrations.

Bevel edges if warranted by material thickness (see Section 3-11). Tack weld a backing strip to the plates to make the first weld pass (root pass) easier.

Single Pass Vertical Butt Joint Weld Or First Pass Of Multi-Layer Deposit

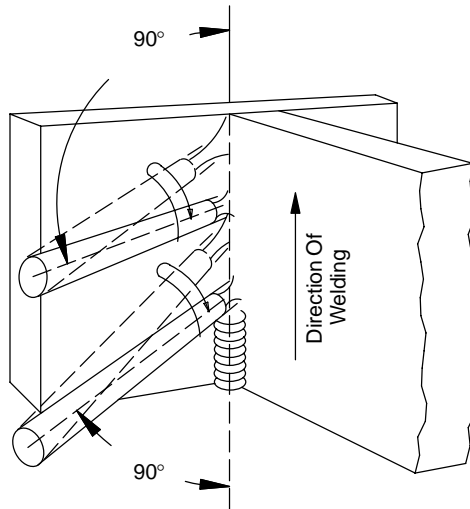


Vertical Butt Joint Weld Subsequent Layers

3-16. Welding Vertical Tee Joints And Lap Joints

Tee Joint Weld

Arrows Show Lifting Up Of Electrode And Return To Crater.

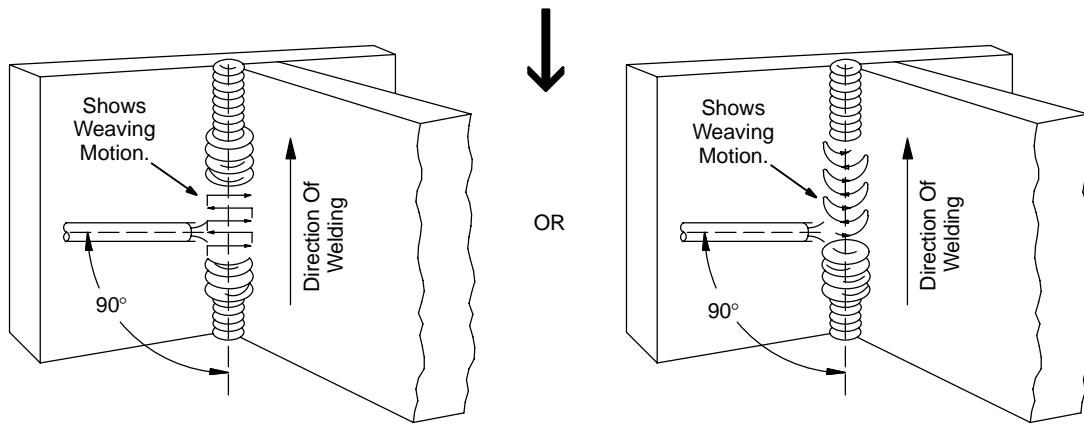


First Weld Pass

☞ When welding vertically, gravity may distort the molten metal.

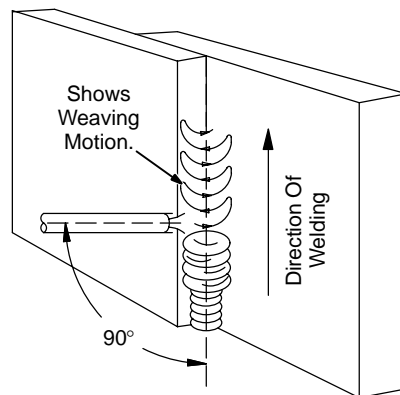
☞ This technique is not suitable for all electrodes.

For maximum strength, weld both sides of joint.



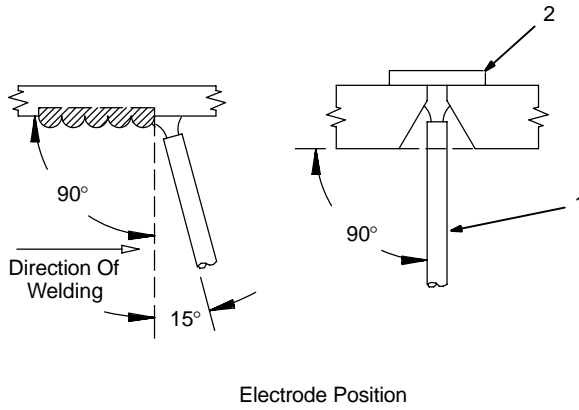
Subsequent Weld Passes

Lap Joint Weld



3-17. Welding Overhead Butt Joints And Tee Joints

Butt Joint Weld



Electrode Position

☞ When welding overhead, gravity may distort the molten metal.

☞ This technique is not suitable for all electrodes.

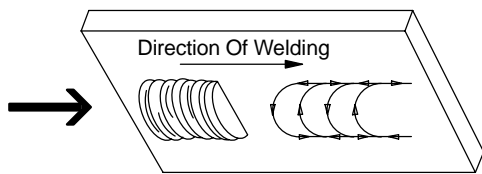
- 1 Electrode
- 2 Backing Strip

Welding overhead is the most difficult welding skill to master.

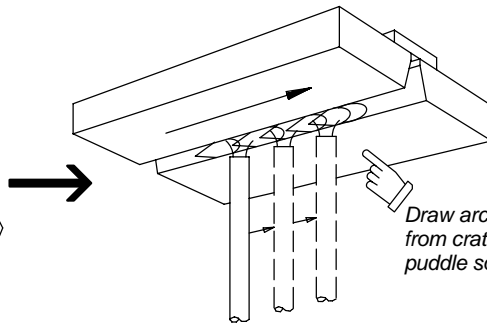
When welding overhead, use a welding motion that draws arc out and slightly away from the crater to allow weld puddle to solidify.

When weaving is necessary, use the pattern shown.

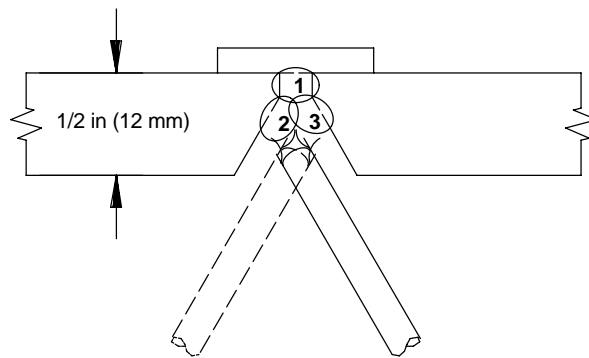
Bevel edges if warranted by material thickness (see Section 3-11). Tack weld a backing strip to the plates to make the first weld pass (root pass) easier.



Welding Patterns

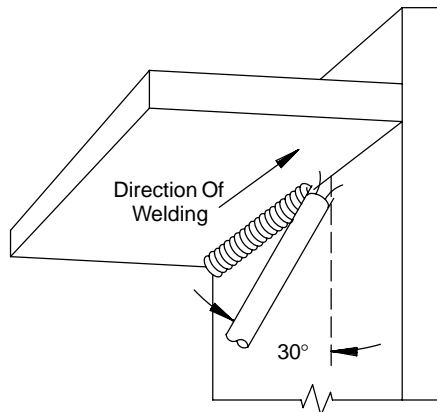


Overhead Welding Technique

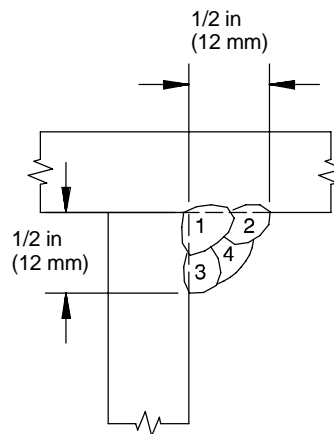


Sequence Of Multiple Weld Passes

Tee Joint Weld

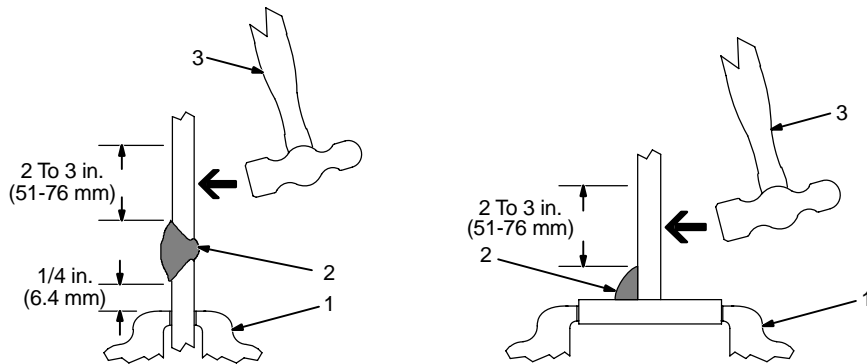


First Weld Pass



Subsequent Weld Passes

3-18. Weld Test



- 1 Vise
- 2 Weld Joint
- 3 Hammer

Strike the weld joint in the direction shown. A good weld bends over but does not break.

If the weld breaks, examine it to determine the cause.

If the weld is porous (many holes), the arc length was probably too long.

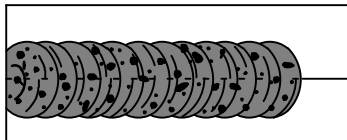
If the weld contains bits of slag, the arc may have been too long or the electrode was moved incorrectly which allowed molten slag to be trapped in the weld. This may happen on a V-groove joint made in several layers and calls for additional cleaning between layers.

If the original beveled surface is visible the material was not fully melted which is often caused by insufficient heat or too fast a travel speed.

S-0057-B

SECTION 4 – WELDING TROUBLESHOOTING

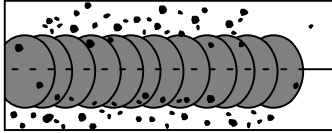
4-1. Porosity



Porosity – small cavities or holes resulting from gas pockets in weld metal.

Possible Causes	Corrective Actions
Arc length too long.	Reduce arc length.
Workpiece dirty.	Remove all grease, oil, moisture, rust, paint, coatings, slag, and dirt from work surface before welding.
Damp electrode.	Use dry electrode.

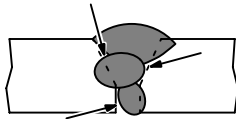
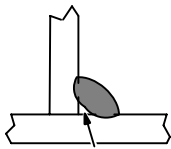
4-2. Excessive Spatter



Excessive Spatter – scattering of molten metal particles that cool to solid form near weld bead.

Possible Causes	Corrective Actions
Amperage too high for electrode.	Decrease amperage or select larger electrode.
Arc length too long or voltage too high.	Reduce arc length or voltage.

4-3. Incomplete Fusion



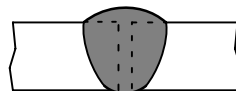
Incomplete Fusion – failure of weld metal to fuse completely with base metal or a preceding weld bead.

Possible Causes	Corrective Actions
Insufficient heat input.	Increase amperage. Select larger electrode and increase amperage.
Improper welding technique.	Place stringer bead in proper location(s) at joint during welding. Adjust work angle or widen groove to access bottom during welding. Momentarily hold arc on groove side walls when using weaving technique. Keep arc on leading edge of weld puddle.
Workpiece dirty.	Remove all grease, oil, moisture, rust, paint, coatings, slag, and dirt from work surface before welding.

4-4. Lack Of Penetration



Lack of Penetration

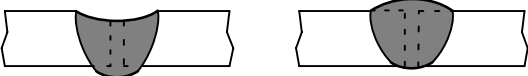


Good Penetration

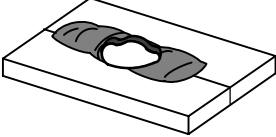
Lack Of Penetration – shallow fusion between weld metal and base metal.

Possible Causes	Corrective Actions
Improper joint preparation.	Material too thick. Joint preparation and design must provide access to bottom of groove.
Improper weld technique.	Keep arc on leading edge of weld puddle. Reduce travel speed.
Insufficient heat input.	Increase amperage. Select larger electrode and increase amperage.

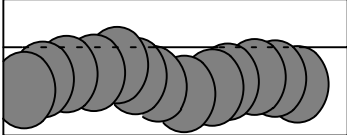
4-5. Excessive Penetration

		<p>Excessive Penetration – weld metal melting through base metal and hanging underneath weld.</p>
<p>Excessive Penetration</p>	<p>Good Penetration</p>	
<p>Possible Causes</p>	<p>Corrective Actions</p>	
<p>Excessive heat input.</p>	<p>Select lower amperage. Use smaller electrode.</p>	
<p>Improper weld technique.</p>	<p>Adjust travel speed.</p>	

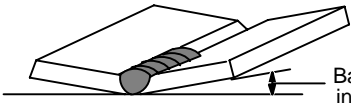
4-6. Burn-Through

		<p>Burn-Through – weld metal melting completely through base metal resulting in holes where no metal remains.</p>
<p>Possible Causes</p>	<p>Corrective Actions</p>	
<p>Excessive heat input.</p>	<p>Select lower amperage. Use smaller electrode. Increase and/or maintain steady travel speed.</p>	

4-7. Waviness Of Bead

		<p>Waviness Of Bead – weld metal that is not parallel and does not cover joint formed by base metal.</p>
<p>Possible Causes</p>	<p>Corrective Actions</p>	
<p>Unsteady hand.</p>	<p>Use two hands. Practice technique.</p>	

4-8. Distortion

		<p>Distortion – contraction of weld metal during welding that forces base metal to move.</p>
<p>Possible Causes</p>	<p>Corrective Actions</p>	
<p>Excessive heat input.</p>	<p>Use restraint (clamp) to hold base metal in position. Make tack welds along joint before starting welding operation. Predict anticipated weld distortion and precamber base metal. Select lower amperage for electrode. Increase travel speed. Weld in small segments and allow cooling between welds.</p>	

Miller Electric Mfg. Co.

An Illinois Tool Works Company
1635 West Spencer Street
Appleton, WI 54914 USA

International Headquarters—USA

USA Phone: 920-735-4505 Auto-Attended
USA & Canada FAX: 920-735-4134
International FAX: 920-735-4125

**European Headquarters –
United Kingdom**

Phone: 44 (0) 1204-593493
FAX: 44 (0) 1204-598066

www.MillerWelds.com

