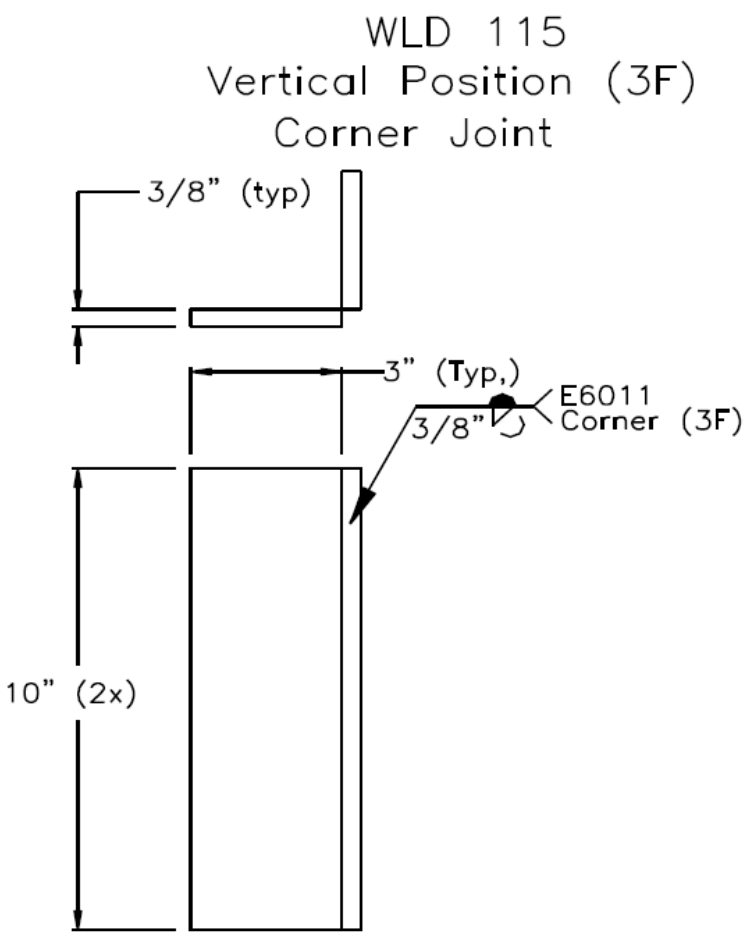
Mr. Gunstenson
Welding

SMAW Task - 6010/6011 Vertical Corner

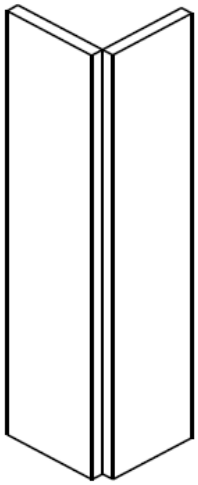
Name: _____ **Date:** _____



Welding Pocedure

1. Electrode — E6011
2. Diameter — 1/8"
3. Polarity — DCRP
4. Amperage — 70 to 95
5. Arc Length — 1/16"–1/8"
6. Welding Position — Vertical–Up (3F)
7. Materal Size — 3/8"x3"x10"
8. Work Angle — 20° to 70°
9. Technique — Stringer "Whip and Pause"

* Use key hole technque on root pass.



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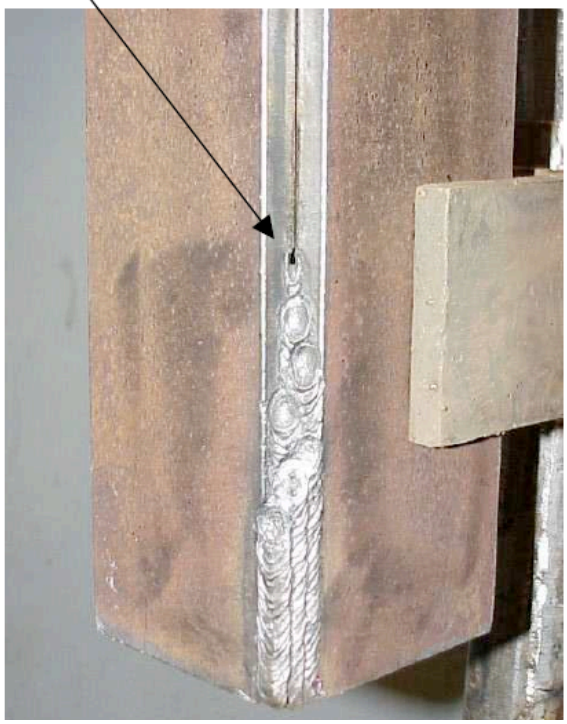
Procedure

1. Do not begin until you teacher instructs you to do so.
2. Obtain a piece of mild steel 3/8" x 6" x 6".
3. Use firebricks, so that only the outer edge is supported by the bricks.
4. The difficulty with this joint configuration is the limited area to weld in due to the joint configuration and the plate thickness. It is important to limit the size of the welds so that equal and smooth fill will be the outcome. It is essential to limit the heat input into the parent material too. Use lower amperages and quench the work piece often.

Keyhole for Complete Joint Penetration



Snap a picture of your final piece and insert it here:

Criteria	Student Assessment	Instructor Assessment
Reinforcement (0” - ⅛”)		
Fillet Weld Size		
Undercut (1/32”)		
Weld Bead Contour (smooth)		

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Penetration			
Cracks (none)			
Arc Strikes (none)			
Fusion (complete)			
Overlap			
Porosity (none)			
		Grade:	**/8**