

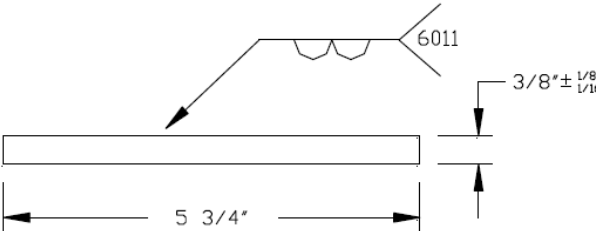
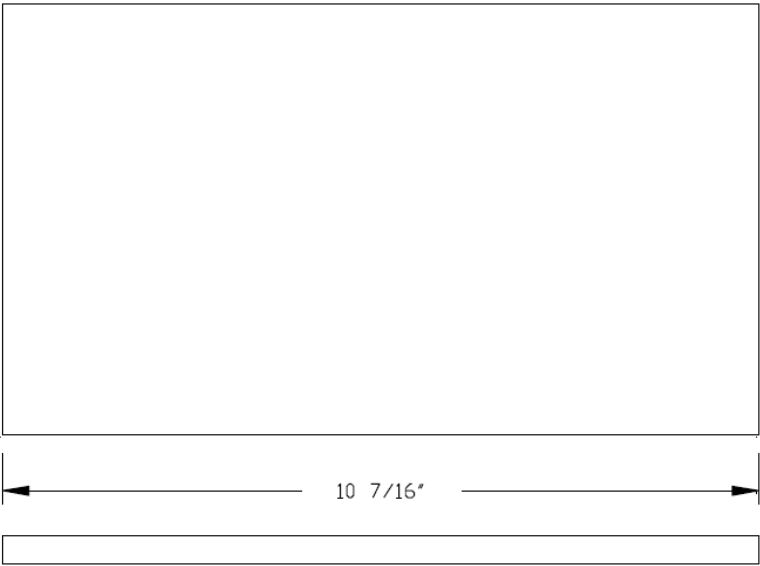
SMAW Task - 6010/6011 Pad

Name: _____

Date: _____

E6011
Flat Position
Bead Plate

- Welding Procedure:
- | | |
|---------------------|---------------------------------|
| 1. Electrode | 6011 |
| 2. Diameter | 1/8" |
| 3. Polarity | DCRP |
| 4. Amperage | 80 to 95 Amps |
| 5. Arc Length | 1/16"-1/8" |
| 6. Welding Position | Flat |
| 7. Travel Angle | 20° |
| 8. Work Angle | 90° to 75° |
| 9. Technique | Stringer bead "whip and pause." |
| 10. Weld Size | 5/16" to 5/8." wide |



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. Place the metal between two firebricks, so that only the outer edge is supported by the bricks.
4. Use a straight whip and pause technique. Allow the puddle to obtain a 3/8" to 1/2" width and step/surge rod in and out of puddle in a rhythm to keep puddle size consistent. The step distance should be approximately 1/2 the puddle length and no more than 1 1/2 the puddle length.
5. Alternate directions of welding for each pass.



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

Criteria	Student Assessment	Instructor Assessment
Reinforcement (0" - 1/8")		
Fillet Weld Size		
Undercut (1/32")		
Weld Bead Contour (smooth)		
Penetration		
Cracks (none)		
Arc Strikes (none)		
Fusion (complete)		
Porosity (none)		

Grade:

/8
