Welding Instructions Mild Steel

WELDING METHOD

Shielded metal arc welding (SMAW) Flux cord arc welding (FCAW)

WELDERS' QUALIFICATION

Welders to be qualified according to AWS D1.1 latest edition

CONSUMABLE SMAW (AWS 7018) FCAW (AWS E-71-T5)

Consumable to be handled and treated according to manufacturer's recommendation.

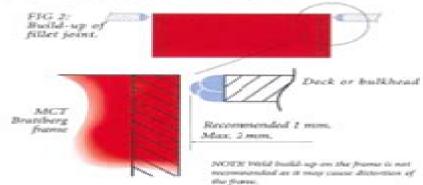
PREPARATION AND FIT UP

The prepared joint and surrounding areas shall be clean and free from moisture, oil, grease, loose or thick scale, oxides etc., or any protective coating except weldable primers.

Maximum allowed root gap for fillet welds is recommended 1 mm, max 2 mm (see fig 1).

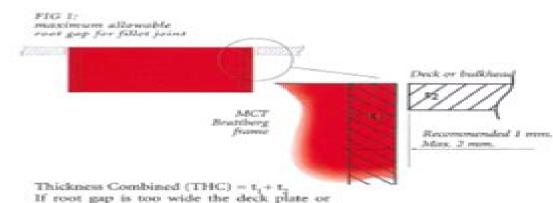
achieve a proper gap.

(see fig. 2)



PREHEAT AND INTERPASS TEMPERATURE

To avoid hydrogen cracking when welding MCT Brattberg frames made of carbon, manganese or micro alloy steel Rel. * 390N/mm³.



bulkhead may be built-up with weld to

IMPORTANTI

To avoid deformation of the frame it is recomended to follow this welding instructions

Putting sofety first



Welding Instructions Guide

United States. Army. Ordnance Corps

Welding Instructions Guide:

Technical Manual United States. War Department, 1949 Arc-welding Manual General Electric Company, 1928 Underwater Cutting and Welding Manual United States. Navy Department. Bureau of Ships, 1954 **Arc-welding** Manual for the Design and Control of Welded Construction United States. Bureau of Reclamation, 1950 **Ordnance** Inspection Administrative Manual: General inspection administrative instructions United States. Army. Ordnance A Quick Guide to Welding and Weld Inspection S E Hughes, 2009-10-20 A concise and accessible guide to the knowledge required to fulfil the role of a welding inspector In covering both European and US based codes the book gives those wishing to gain certification in welding inspection a basic all round understanding of the main subject matter A concise and accessible guide to the knowledge required to fulfil the role of a welding inspector Covers both European and US based codes Gives those wishing to gain certification in welding inspection a basic all round understanding of the main subject Marine safety manual United States. Coast Guard, 1985 Vocational Education: State Instruction Materials for matter ... Curriculum and Instructional Materials Center (Okla.), Texas Education Agency. Department of Occupational Education Marine Safety Manual: Technical United States. Coast Guard, 1985 and Technology, 1973 The Oxwelder's Manual Oxweld acetylene Company, 1925 Bibliography of Scientific and Industrial Reports ,1946 *Vocational Education :* State Instruction Materials for ... Oklahoma. State Department of Vocational and Technical Education. Curriculum and Welding Processes Handbook Klas Weman, 2003 Welding processes handbookis Instructional Materials Center, 1974 an introductory guide to all of the main welding processes It is specifically designed for students on EWF courses and newcomers to welding and is suitable as a textbook for European welding courses in accordance with guidelines from the European Welding Federation Welding processes and equipment necessary for each process are described so that they can be applied to all instruction levels required by the EWF and the important areas of welded joint design quality assurance and costing are also covered in detail Manual of Engineering Drawing Colin H. Simmons, Dennis E. Maguire, 2009-03-24 The Manual of Engineering Drawing has long been the recognised as a guide for practicing and student engineers to producing engineering drawings and annotated 3D models that comply with the latest British and ISO Standards of Technical Product Specifications and Documentation This new edition has been updated to include the requirements of BS8888 2008 and the relevant ISO Standards and is ideal for International readership it includes a guide to the fundamental differences between the ISO and ASME Standards relating to Technical Product Specification and Documentation Equally applicable to CAD and manual drawing it includes the latest development in 3D annotation and the specification of surface texture The Duality Principle is introduced as this important concept is still very relevant in the new world of 3D Technical Product Specification Written by members of BSI and ISO committees and a former college lecturer the Manual of Engineering Drawing combines up to the minute technical information with clear readable explanations and numerous diagrams and

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Occupational Outlook Handbook ,2000 Describes 250 occupations which cover approximately 107 million jobs

Resources in Education ,1989 Manual Training Magazine Charles Alpheus Bennett,1918 Welding Theory and

Application United States. War Department,1943

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