

Welding Theory – 1069-01 – Notes

Welding Defects:

Porosity: is imperfections caused by contaminations. I.e., bubbles.

- Is caused by atmospheric contamination
- Foreign contamination
 - o Grease
 - o Oils
 - o Plating
 - o Rust
 - o Paint

Rolled Welds: Is when the weld rolls over itself.

- Is caused by speed problems. (to slow)
- Wire feed speed
- Wrong work angle

Undercut: Is when the wire goes too deep into the metal by the toe.

- Is caused by speed (way too slow/too hot)
- Wire feed speed (too insufficient)
- Work angles

Spatter: is the little pieces of metal that shoots away from the arc.

- Inductance imbalance
- Voltage settings
- Wire feed speed

Slag inclusions: Is when you end up welding foreign pieces into the weld.

Arc strikes: are sending an electrical current through somewhere that wasn't meant to be welded.

Incomplete fusion: Is when the weld isn't completely fused to your base metal.

Improper leg lengths: Is when the length of the leg we weld is not to the specifications given.

Inductance changes the rate at which the wire collapses into a weld

Burn back is a setting you can change in the welding machine.

Blind's Nest: A bird's nest is when the wire tangles up inside of the machine. This is one of the causes for the wire not coming out of the tip.

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