Effective Stainless Steel Pipe Welding

1. Preparation & Technique



Select Technique: GTAW (Gas Tungsten Arc Welding)

Precision & Control



Material Preparation:

 Clean pipes thoroughly (Oil, grease, roides)

 Use Acetone or SS Brush (Prevent contamination)



Edge Preparation:

- Bevel edges (V-groove) (For full penetration)

2. Equipment Setup



Power Source:

- Suitable Voltage
- Suitable Amperage



Shielding Gas:

- Argon-based (Prevent oxidation)



Filler Metals:

Low-carbon (ER306L/ER316L)
 (Minimize corresion risks)

3. Welding Process



Maintain Consistent:

- Travel Speed
- Travel Angle



Back Purging:

 Inert gas inside pipe (Avoid sugaring)



Tack-Weld Frequently:

- Manage heat
- Prevent distortion



Execute Passes Methodically:

- Root, Filler, Cap.



Interpass Temperature:

- Below 300°F (Avoid warping)

Welding And Pipe Study Guide

Sabine Zange

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