

# EFFECTIVE 90° PIPE WELDING

## 01 PREPARATION



- Thoroughly clean pipe surfaces (remove rust, oil, etc.).
- Cut ends precisely and ensure a snug 90° fit.
- Bevel edges on thicker pipes for deeper penetration.

## 02 SECURING



- Use clamps or a jig to prevent any movement.
- Double-check alignment to avoid gaps or errors.

## 03 WELDING PROCESS



**Root Pass:** Use E6010 for strong penetration.  
**Fill Passes:** Build up the weld for good fusion.  
**Cap Pass:** Create a smooth, finished surface.  
**Key Principles:** Control angle, speed, and heat.

## WELDING POSITIONS



### Flat Position

Pipe is horizontal. Ideal for beginners.



### Horizontal Position

Pipe is vertical. Requires careful control.



### Vertical Position

More challenging. Use zigzag motion.



**SAFETY ADVISORY:** Always wear appropriate PPE and ensure the work area is well-ventilated.

# Welding And Pipe Study Guide

**A.L. DYKE**

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