

# Effective Stainless Steel Pipe Welding

## 1. Preparation & Technique



Selected Technique: GTAW  
(Gas Tungsten Arc Welding)  
- Precision & Control



Material Preparation:  
- Clean pipes thoroughly  
(Oil, grease, oxides)  
- 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 Metal:  
- Low-carbon (ER308L/ER316L)  
(Minimize corrosion 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

**David H. Hartzog**

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