

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

**American Vocational Association.
Agricultural Education Section**

Welding And Pipe Study Guide:

Pipefitter's Licensing Study Guide Rex Miller, Mark R. Miller, 2021-03-26 Pass any pipefitter's licensing and certification exam on the first try. This highly effective self study guide provides everything you need to prepare for any major pipefitter's licensing and certification exam. Written by a pair of industrial technology experts and experienced trainers. Pipefitter's Licensing Study Guide features hands on coverage of the latest equipment, techniques and regulations. Each chapter contains multiple choice questions to help you review the material covered and practice the types of questions that typically appear on pipefitting licensing tests. Tips on troubleshooting and working with pipes appear throughout. In depth coverage includes: The history of pipefitting, Working with pipe, Pipe fabrication codes and standards, Soldering, welding, brazing and chemical bonding, Offset connections and screwed and flanged fittings, Pipe valves and fittings, Cast iron, clay, fiber and metal pipes.

Reading piping and welding blueprints, Troubleshooting pipe fittings, **Summaries of Studies in Agricultural Education**, American Vocational Association, Agricultural Education Section, 1961, **Curriculum Materials for Trade and Industrial Education**, 1961, *Study Guide and Exercises for Welding Processes and Power Sources* Edward R. Pierre, 1985

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Welding Design & Fabrication, 1977, *Text Book FOR Dyke's Home Study Course OF Automobile Engineering* A.L. DYKE, 1919, **Farm Mechanics Shop Guide** David H. Hartzog, 1956, Welding Engineer, 1928, **Pacific Marine Review**, 1944-07, *The Welding Encyclopedia*, 1930, Gas Age, 1914 Includes summaries of proceedings and addresses of annual meetings of various gas associations. L C set includes an index to these proceedings 1884-1902 issued as a supplement to *Progressive age* Feb 15 1910, Educational Screen and Audiovisual Guide, 1928, Journal of the American Welding Society American Welding Society, 1929 Current welding literature included in each volume, **A Practical Manual of Autogenous Welding (oxy-acetylene)** Raphaël Granjon, P. Rosenberg, 1915, **A Practical Manual of Autogenous Welding (oxyacetylene): with a Chapter on the Cutting of Metals with the Blowpipe** Raphaël Granjon, 1914, Studies and Reports, 1924, **Industrial Education**, 1982

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