

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



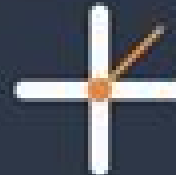
Root Pass: Use E6010 for strong penetration.

Fill Passes: Build up the weld for good fusion.

Cap Pass: Create a smooth, finished surface.

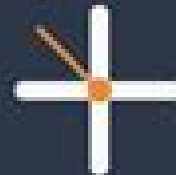
Key Principles: Control angle, speed, and heat.

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:

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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 **Vocational Division Bulletin**, 1961 **Vocational Education Bulletin** United States. Division of Vocational Education, 1961 **Vocational Division Bulletin** United States. Division of Vocational Education, 1939 *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. Rosemberg, 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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