

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



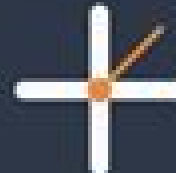
Root Pass: Use E6010 for strong penetration.

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 Welding Society

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