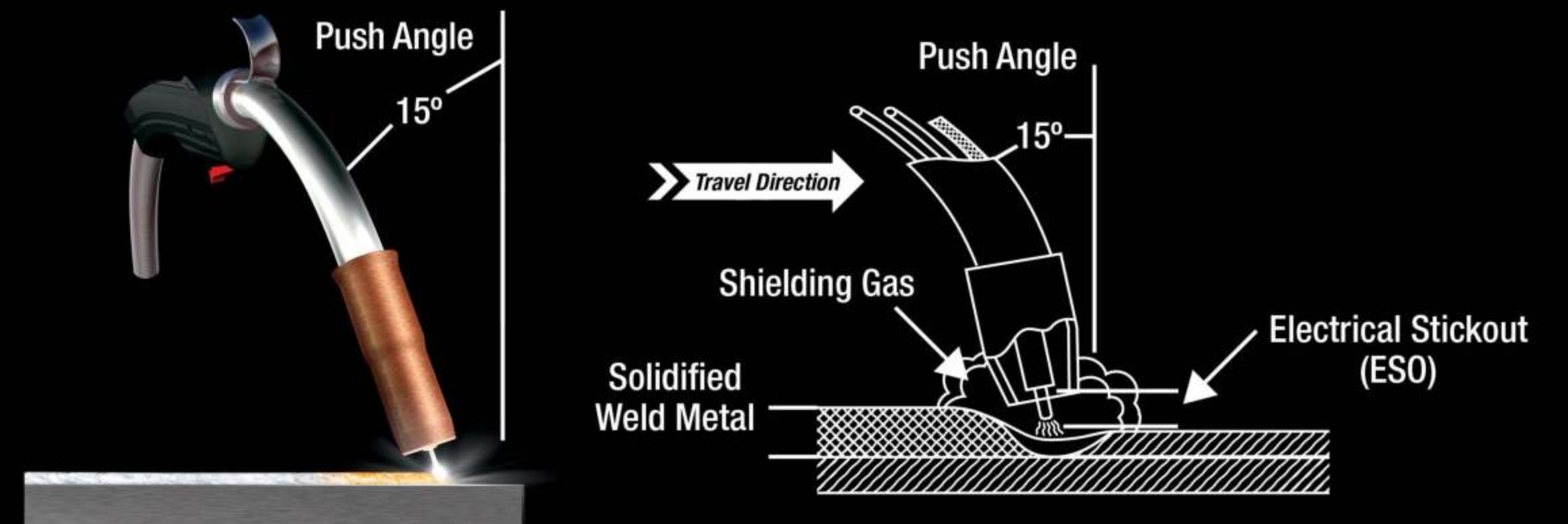
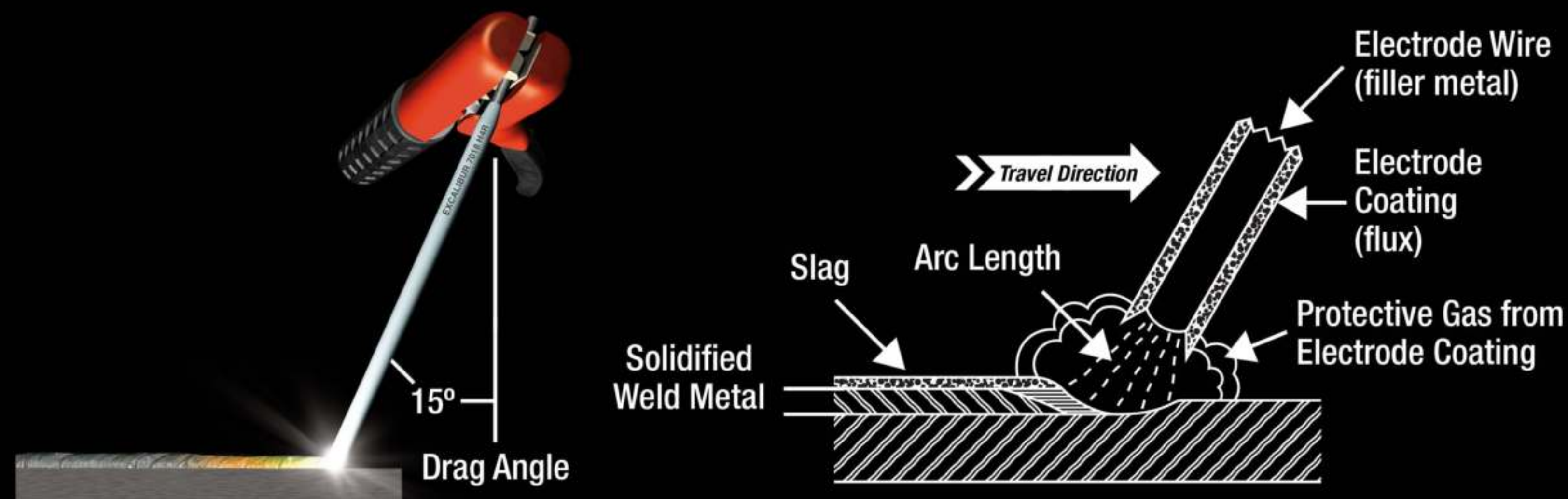


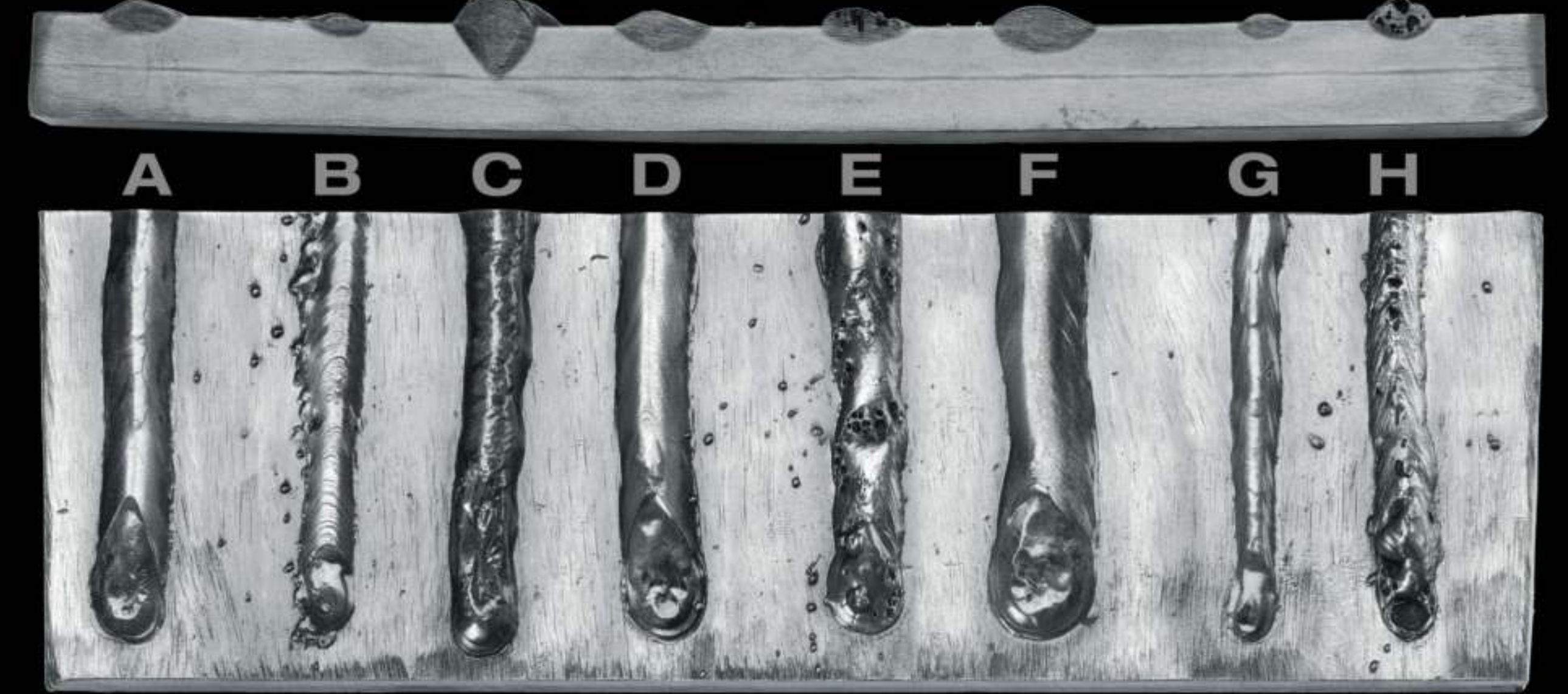
Effects of Welding Variables

SHIELDED METAL ARC WELDING

GAS METAL ARC WELDING



- A. Proper current, travel speed & arc length
- B. Current too low
- C. Current too high
- D. Arc length too short
- E. Arc length too long
- F. Travel speed too slow
- G. Travel speed too fast



- A. Proper wire feed speed (WFS), voltage, Electrical Stickout (ESO) & travel speed
- B. WFS too low
- C. WFS too high
- D. Electrical Stickout (ESO) too short
- E. Electrical Stickout (ESO) too long
- F. Travel speed too slow
- G. Travel speed too fast
- H. Inadequate gas coverage



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