

EXERCISE 1

Make a butt joint of two flat pieces of steel stock with one pass.

- A. Bevel edges of metal to be jointed about $\frac{3}{4}$ of the way down from top. (Use $\frac{1}{4}$ " thick metal, 6" long, 2" wide.)
- B. With bevels forming a vee, butt edges to be welded, leaving $\frac{3}{32}$ " space.
- C. Using proper arc, amperage, and travel, lay a bead, filling the vee gap in one pass.

SINGLE PASS



EXERCISE 2

Make a butt joint of two flat pieces of steel stock using multiple pass.

- A. Bevel edges of metal to be joined about $\frac{3}{4}$ of the way down from the top. (Use $\frac{1}{4}$ " thick metal, 6" long, 2" wide.)
- B. Butt metal pieces to form a vee.
- C. Using proper welding methods, lay a bead the length of the vee at the bottom of the vee.
- D. Knock off slag over first bead with metal hammer.
- E. Lay a second bead to the side of first one, overlapping first about halfway.
- F. Knock off slag formed on second bead.
- G. Lay a third bead on other side of second, filling up the vee, level with top of metal.

MULTIPLE PASS

