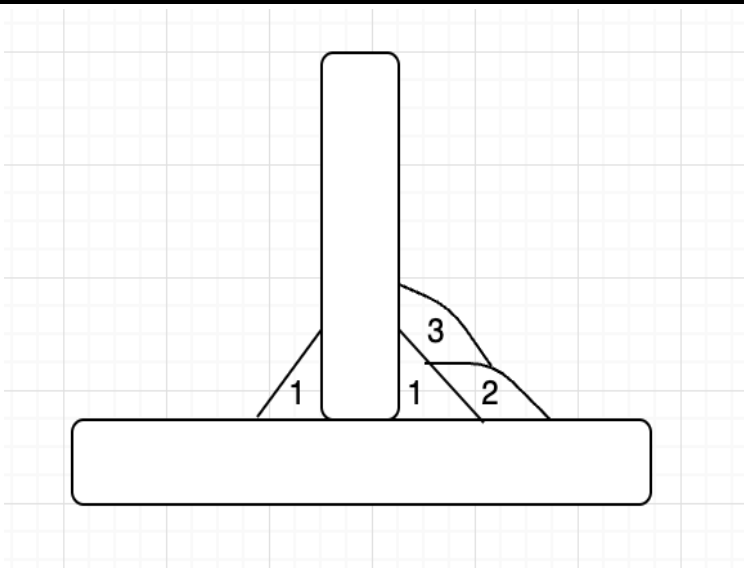


WELDING APPLICATIONS

SkillsUSA District 2024 Welding Competition

T Joint, Fillet Weld
Welding Position: Horizontal (2F)

Welding Process: SMAW, DC+



Welding Pass	1	2	3
Bead Type	Stringer	Stringer	Stringer
Electrode Size	1/8	1/8	1/8
Electrode Classification	E6010	E7018	E7018
Current (amp) DC	70-100	100-150	100-150
Polarity	DC+	DC+	DC+
Volts	23-19	23-19	23-19
Arc Speed (in./ min)	5-6	5-6	5-6