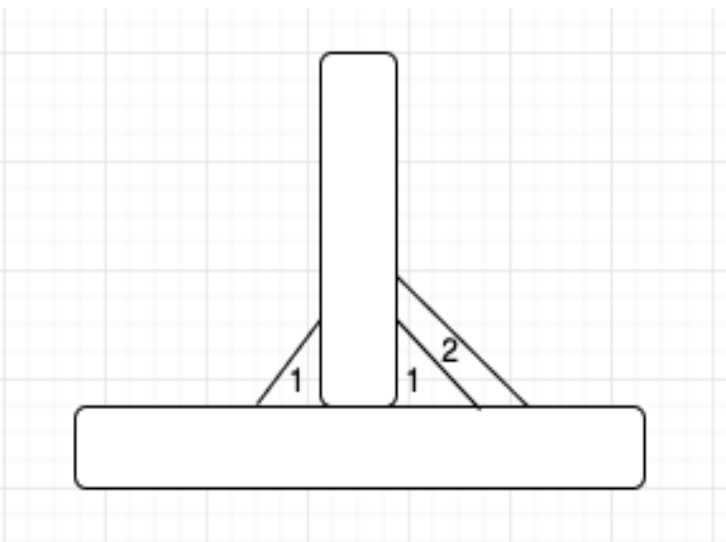


WELDING I

SkillsUSA District 2024 Welding Competition

T Joint, Fillet Weld
Welding Position: Vertical (3F)

Welding Process: SMAW, DC+



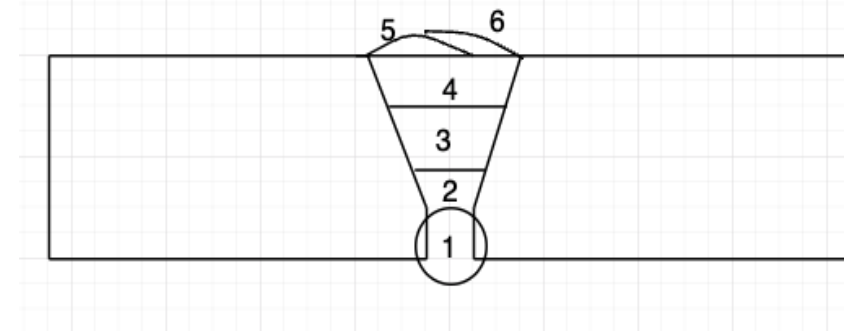
Welding Pass	1	2	
Bead Type	Stringer	Weave	
Electrode Progression	Uphill	Uphill	
Electrode Size	1/8	1/8	
Electrode Classification	E6010	E7018	
Current (amp) DC	70-100	100-150	
Polarity	DC+	DC+	
Volts	23-19	23-19	
Arc Speed (in./ min)	5-6	5-6	

SkillsUSA District 2024 Welding Competition

V Groove Weld
Welding Position: Horizontal (1G)

Welding Process: SMAW, DC+

Note: Total number of passes may vary depending on technique



Welding Pass	1	2-4	5-6
Bead Type	Stringer	Weave	Stringer
Electrode Size	1/8	1/8	1/8
Electrode Classification	E6010	E7018	E7018
Current (amp) DC	70-100	100-150	100-15-
Polarity	DC+	DC+	DC+

Volts	23-19	23-19	23-19
Arc Speed (in./ min)	4-5	5-6	5-6