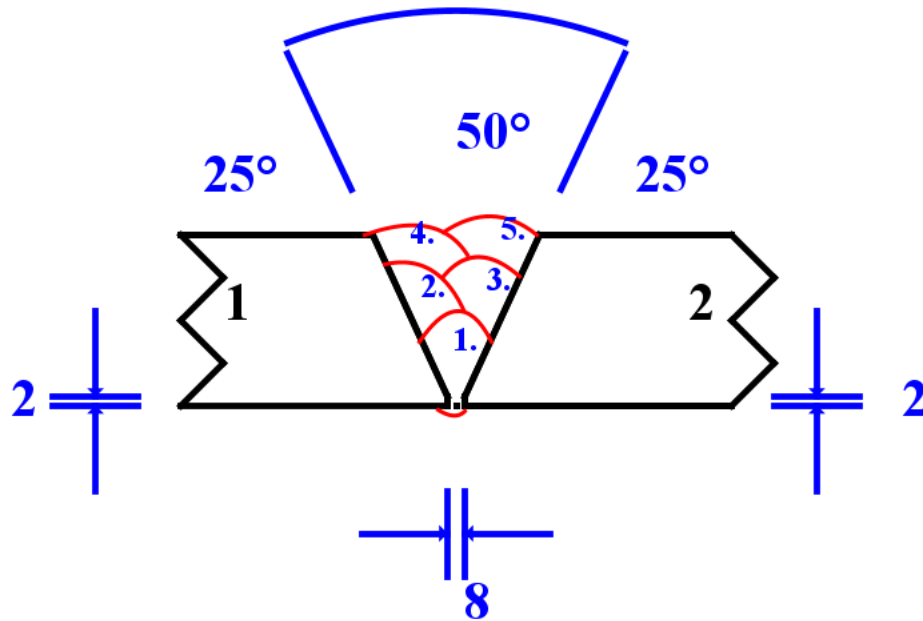


Joint program

Weld IT has created a joint program that can make both joint and string drawings, for use in the creation of a WPS. The program creates images based on input from users, to create realistic dimensions, a typically image can look like this test image:



Weld TEST

Below is a description of how the program works:

Weld IT - Joint program

Info Butt weld Fillet weld Corner weld Overlap weld Flanged weld Cam steel

Butt weld specifications

Recommended choice

Choose left design: Choose right design:

Give values for variables on left side: Give values for variables on right side:

Gap	4	Gap	4
Dy	0	Dy	0
Tickness	40	Tickness	40
Top angle	25	Top angle	25
Top radius	5	Top radius	5
Bottom angle	25	Bottom angle	25
Bottom Radius	5	Bottom Radius	5
Face	2	Face	2
Center	20	Center	20

Generate left side Generate right side

Comments:

Number of pictures on same screen:

4 parts 2 horizontal parts 2 vertical parts 1 picture

Upper left Upper right Upper Left Single

Lower left Lower right & finishing Lower & finishing Right & finishing Entire screen

Look at images

With values on drawing

Here you can choose the type of weld, that you want to draw

Here you can choose the design of the left and right plate

The values given here will define the shape of the left and right plate.

In order to activate the given values and create a drawing, you have to press the blue button for left side, and then the right side. Then a window will appear and show the joint drawing.

Here you can type in a comment, that will appear on the drawing, when the blue button for generated left side and right side is activated

Here you can choose how many drawings you want on one picture. The max limit is 4 different drawings, due to size limitations on the WPS form.

This will show the common combinations of joint preparation that will apply to the chosen design on

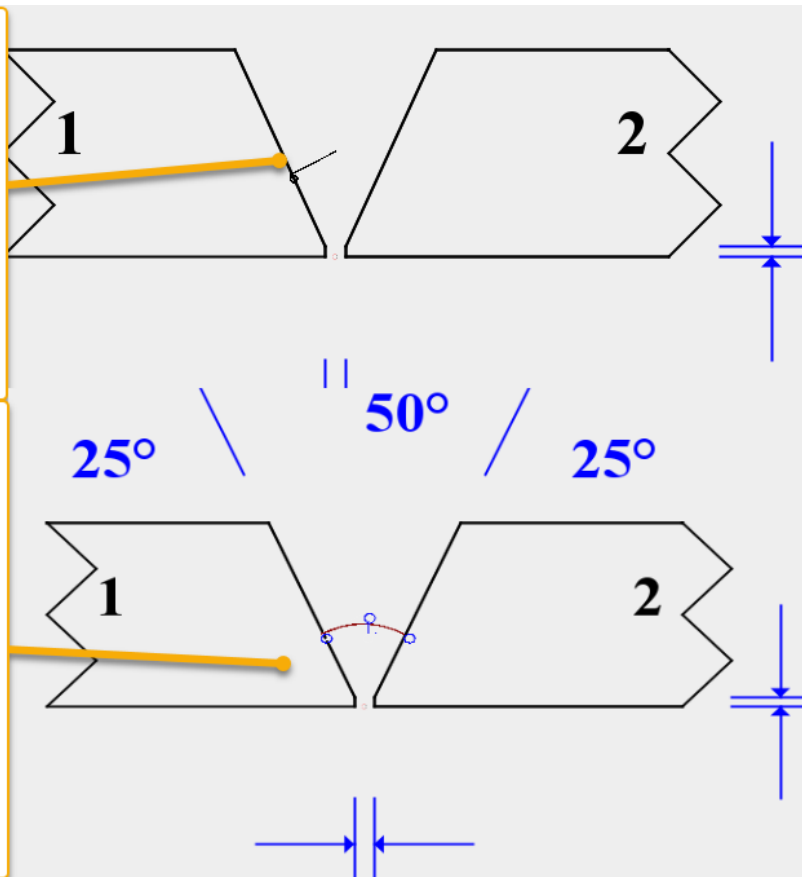
Here you can choose not to show the given values, when the joint drawing is generated

This button gives you the ability to see the preview of last drawn joint

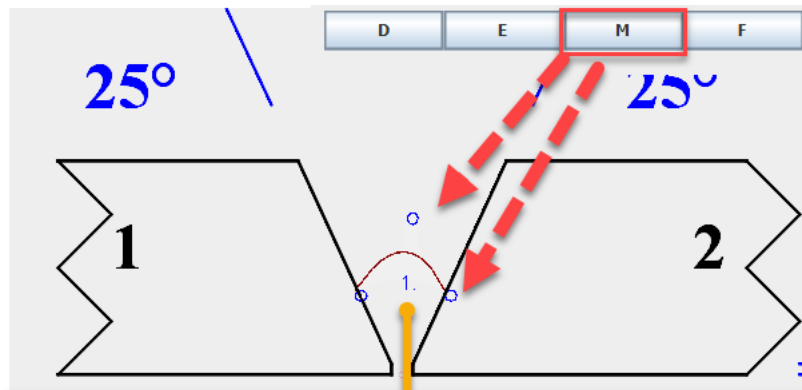
Drawing window:

1. In order to create a string drawing you point the mouse hand to the point where you want the string to start, and push the right mouse button. You will then get a start point marked by a circle. After that you press the right mouse button where you want the top of the weld string to be. Then you will get a black line between the points.

2. When you have the black line, you choose a point where you want the string to end, and use the right mouse button to click on it. The program will then create an arc with three circles, and a string number shown in the second picture.

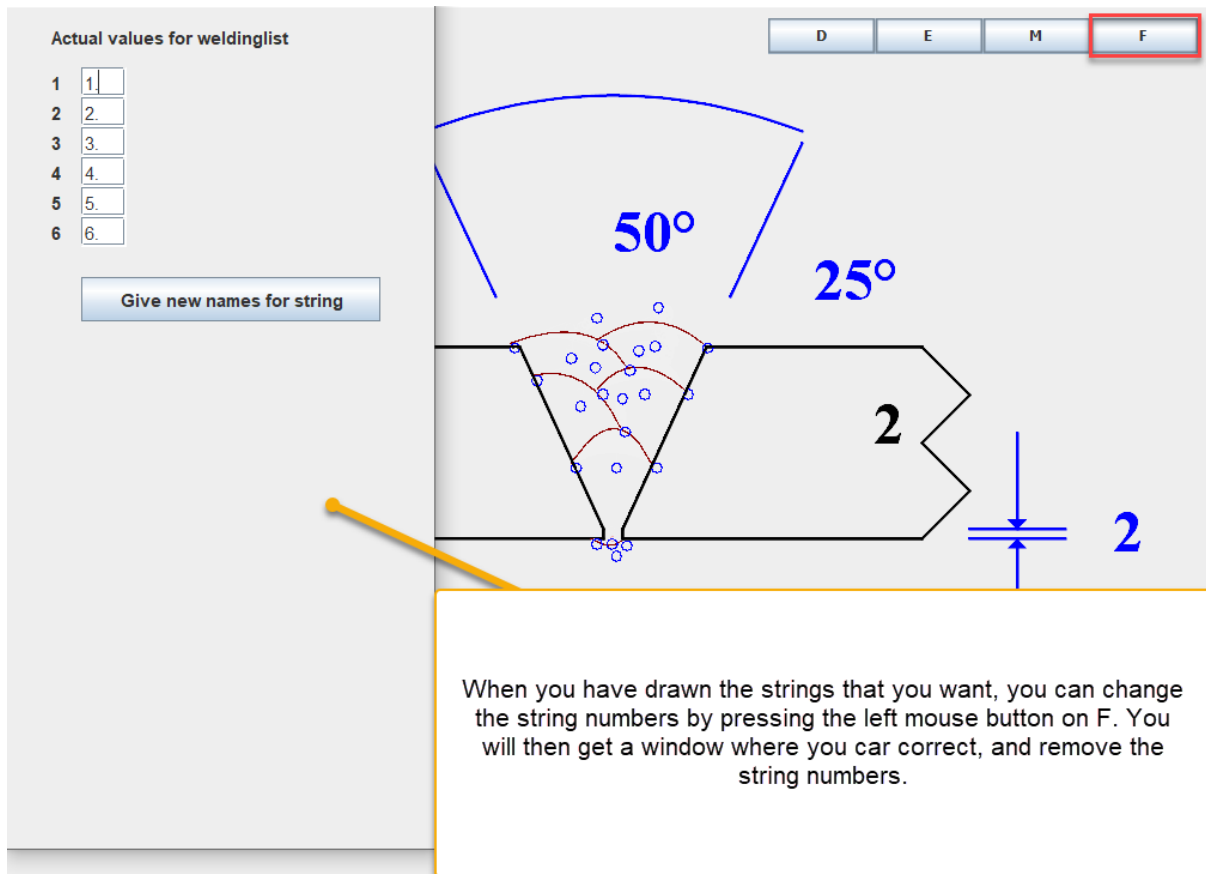


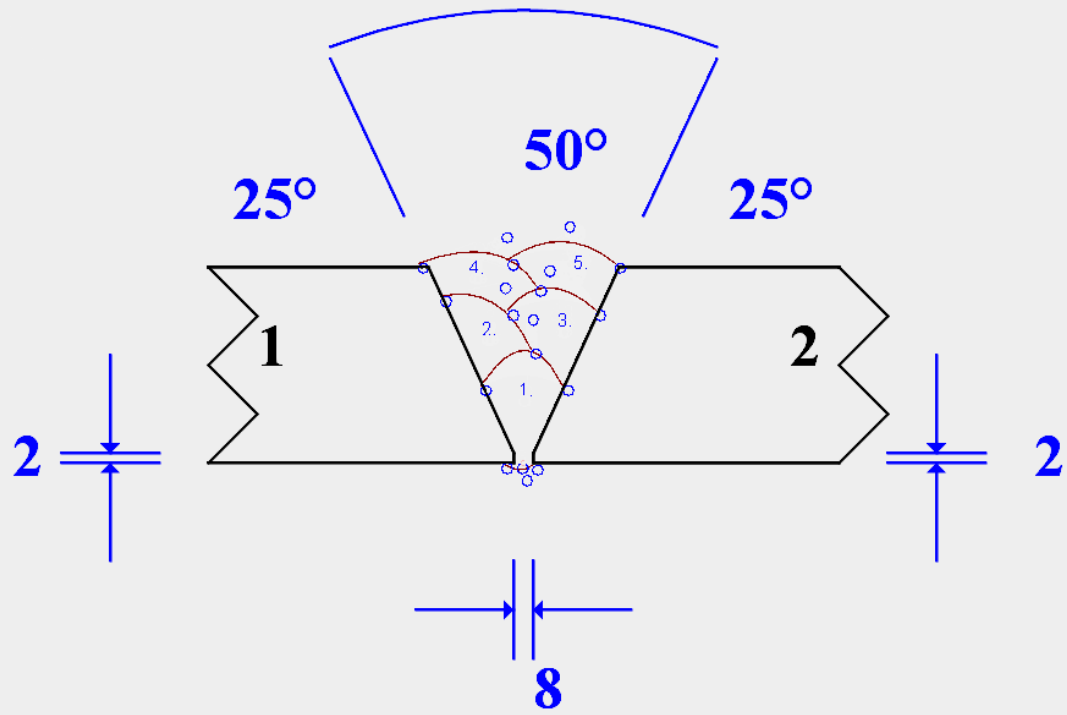
String buildup:



To adjust the drawn string, you have to press the M button with the left mouse button. Then the mouse cursor shifts to a cross, and then you can use the left mouse button to move the string around. To do this you have to have the mouse cross in the center of the circle that you want to move. You can also move the weld string number.

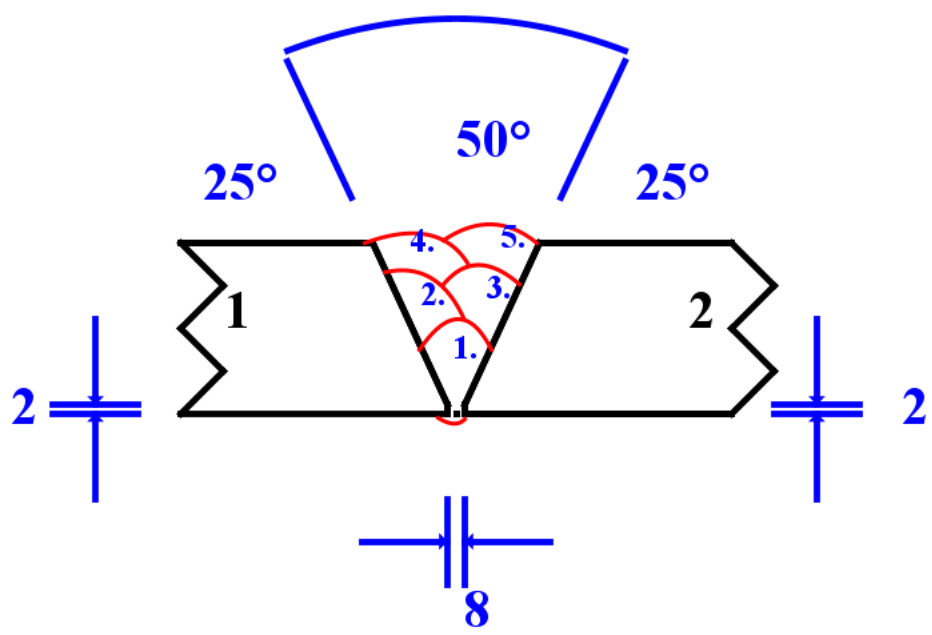
If you want to delete a welding string, you must push the E button in the panel menu located in the upper corner of the drawing picture. A cross will show, and you place it on one of the small blue circles, related to the string that you want to remove. And then click the middle mouse button, to get the string removed.





Weld TEST

The final picture will look like this:



Weld TEST

Creation of two pictures in one frame:

Weld IT - Joint drawing

D E M F

25°

1

2

2

8

Left side:

Gap	4	mm
Dy	0	mm
Plate 1	40	mm
Angle	25°	
Face	2	mm

Right side:

Gap	4	mm
Dy	0	mm
Plate 2	40	mm

Here you can get the given values for both left and right side, on the upper picture. To create the string buildup picture below, you have to select the lower and finishing radio-button in the red box in this picture before you generate a new picture.

☐ Upper left ☐ Upper right ☒ Upper ☐ Left ☐ Single
☐ Lower left ☐ Lower right & finishing ☐ Lower & finishing ☐ Right & finishing ☐ Entire screen

Look at images

Indication of images in buffer

1 2
3 4

Picture nr 2:

Actual values for weldinglist

1	1
2	2
3	3
4	4
5	5
6	

Give new names for string

D

E

M

F

☐ Upper left

☐ Lower left

☐ Upper right

☐ Lower right & finishing

☐ Upper

☒ Lower & finishing

☐ Left

☐ Right & finishing

☐ Single

☐ Entire screen

Look at images

Indication of images in buffer

1

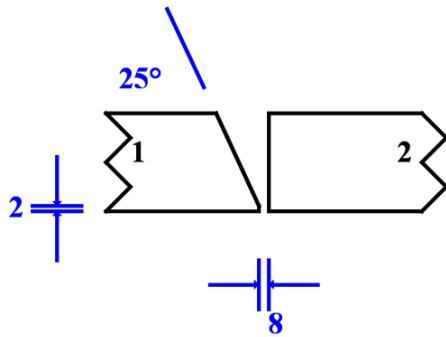
2

3

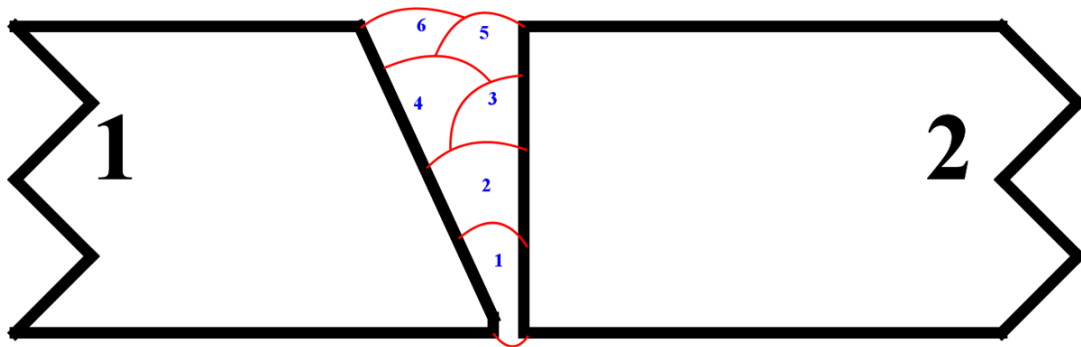
4

On the last photo you can build up the strings, and change or remove string numbers, the same way as on single picture.

When you have drawn the strings and corrected the string numbers. Will the last picture be created, and it will look like this. One small drawing with the given values, and one bigger to show the string buildup.



Left side:			Right side:		
Gap	4	mm	Gap	4	mm
Dy	0	mm	Dy	0	mm
Plate 1	40	mm	Plate 2	40	mm
Angle	25°				
Face	2	mm			



Four pictures in one frame:

Number of pictures on same screen

4 parts

☒ Upper left

☐ Upper right

☐ Lower left

☐ Lower right & finishing

2 horizontal parts

☐ Upper

☐ Lower & finishing

2 vertical parts

☐ Left

☐ Right & finishing

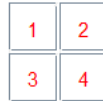
1 picture

☐ Single

☐ Entire screen

Look at images

Indication of images in buffer



Choose where you want the picture to show in the frame. The frame with red numbers indicates where he created pictures is placed

Illustration on 4 different welds in one frame. NB it's important to choose where you want the picture, if you don't choose a new place, the old picture will be overwritten if it's in the same place.

Below is a picture of 4 different joints combined in a single frame:

