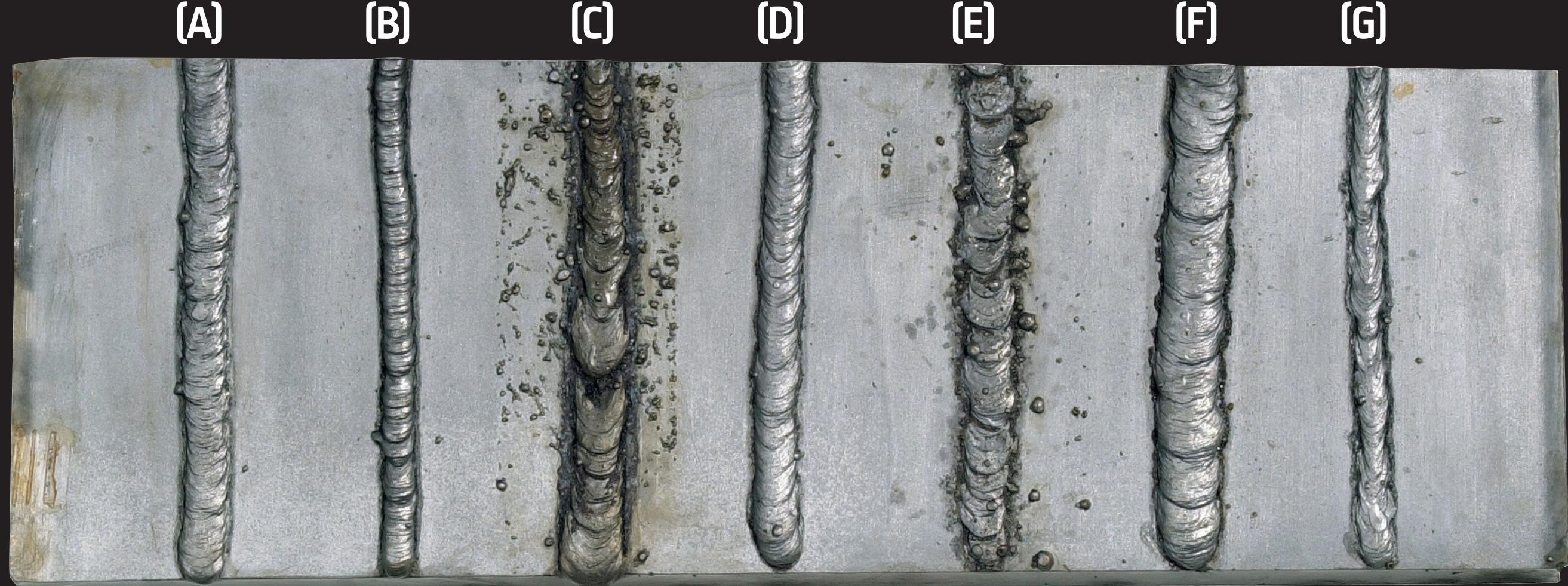
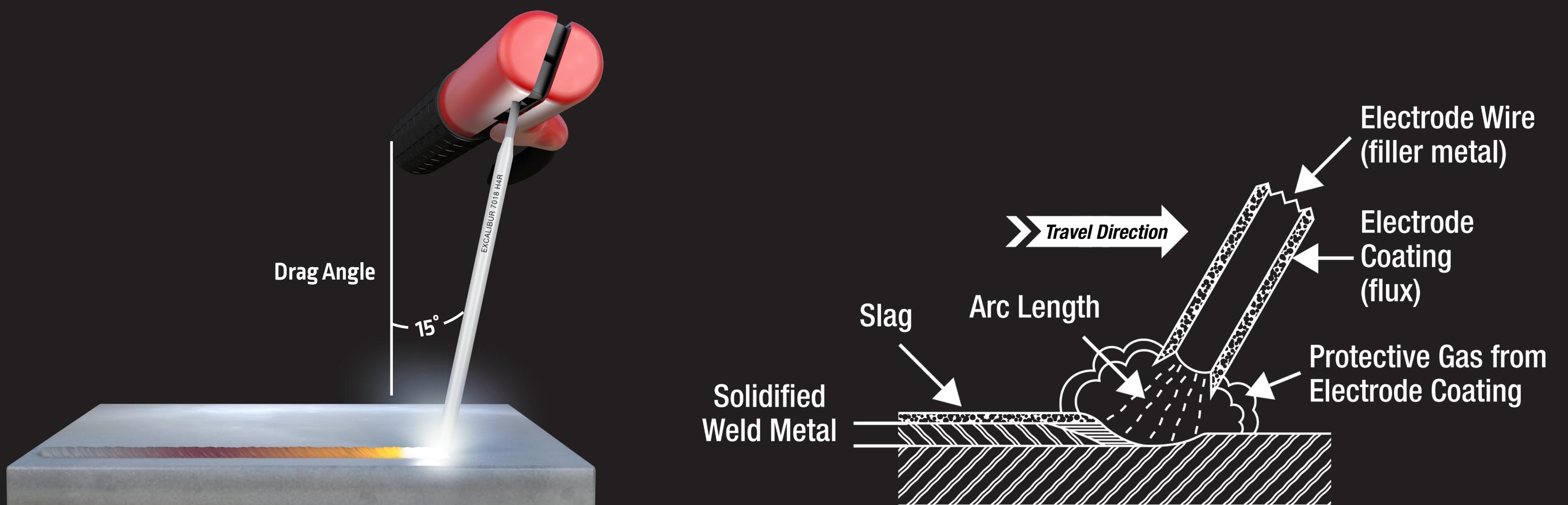


Effects of Welding Variables

SHIELDED METAL ARC WELDING



[A] Proper current, travel speed & arc length

[B] Current too low

[C] Current too high

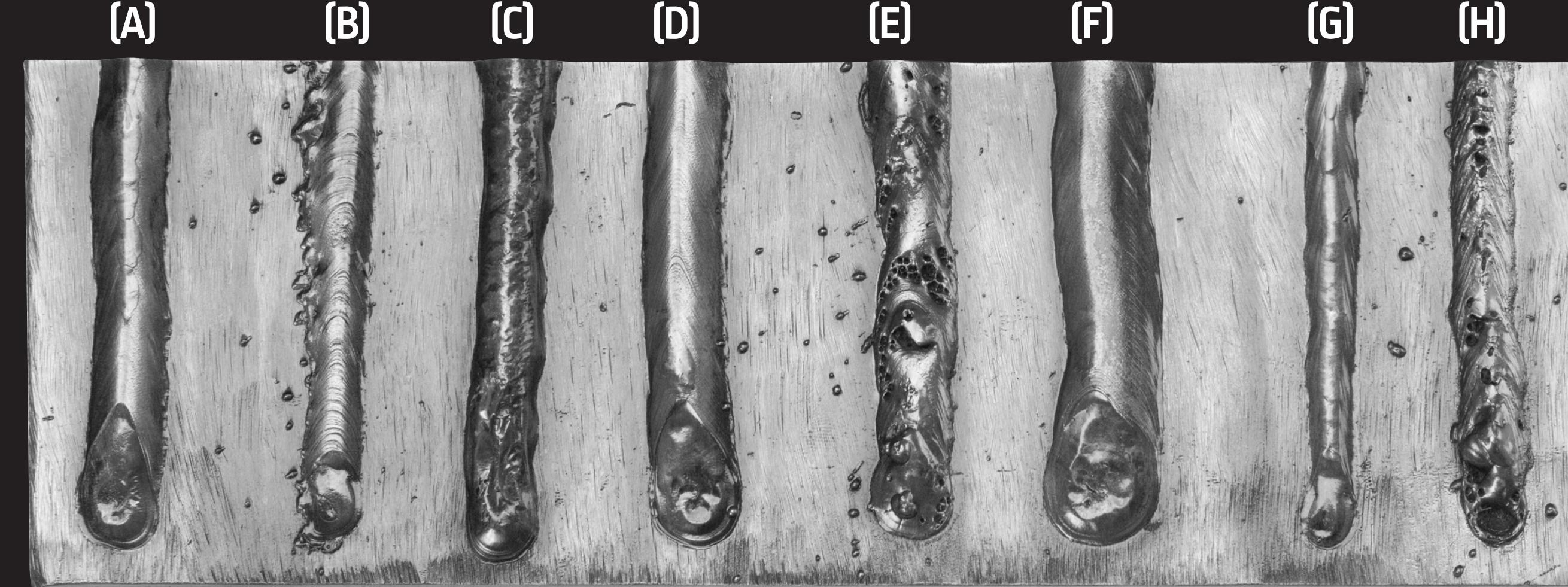
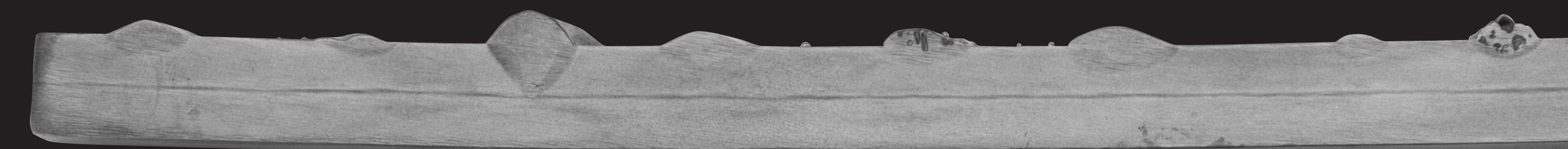
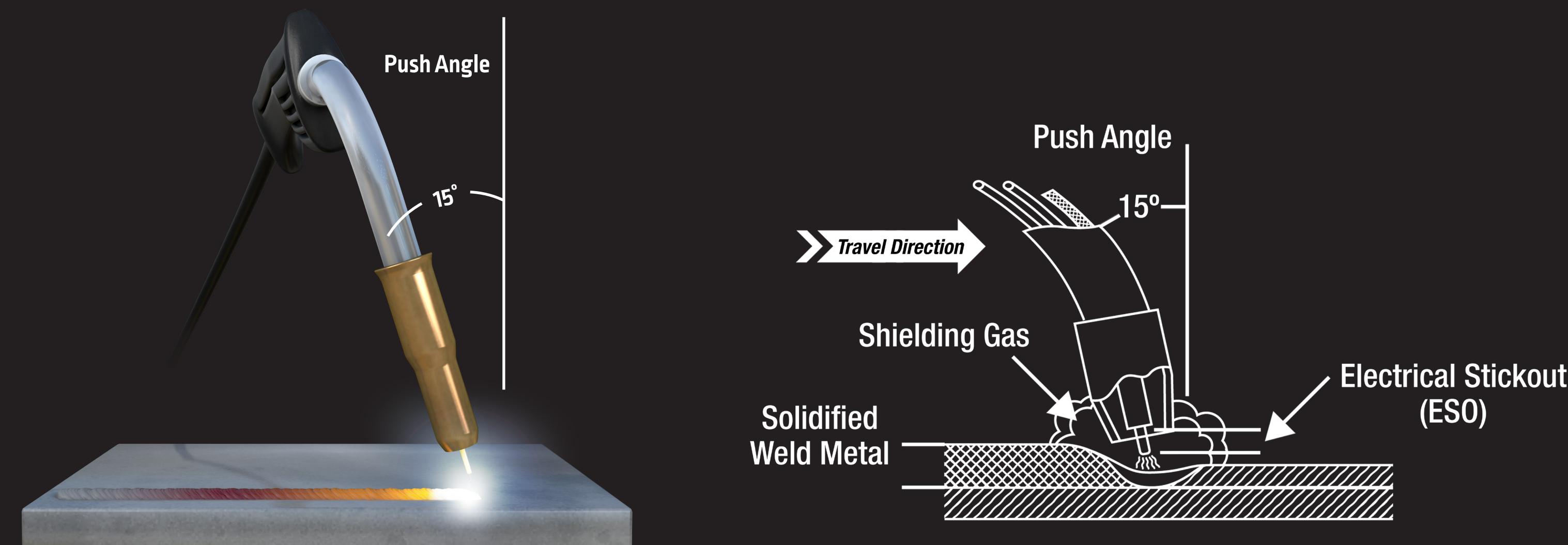
[D] Arc length too short

[E] Arc length too long

[F] Travel speed too slow

[G] Travel speed too fast

GAS METAL ARC WELDING



[A] Proper wire feed speed (WFS), voltage, electrical stick-out (ESO) and travel speed

[B] WFS too low

[C] WFS too high

[D] Electrical stick-out (ESO) too short

[E] Electrical stick-out (ESO) too long

[F] Travel speed too slow

[G] Travel speed too fast

[H] Inadequate gas coverage