

Welding Instructions Mild Steel

WELDING METHOD

Shielded metal arc welding (SMAW)
Flux cord arc welding (FCAW)

WELDERS' QUALIFICATION

Welders to be qualified according to AWS D1.1 latest edition

CONSUMABLE

SMAW (AWS 7018)

FCAW (AWS E-71-T5)

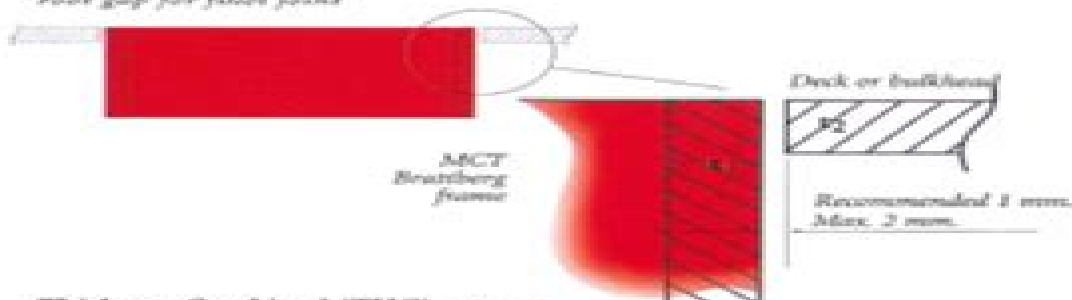
Consumable to be handled and treated according to manufacturer's recommendation.

PREPARATION AND FIT UP

The prepared joint and surrounding areas shall be clean and free from moisture, oil, grease, loose or thick scale, oxides etc., or any protective coating except weldable primers.

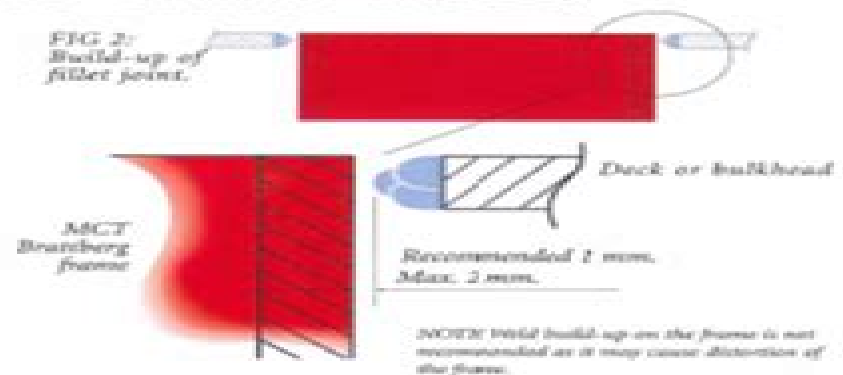
Maximum allowed root gap for fillet welds is recommended 1 mm, max 2 mm (see fig. 1).

FIG 1:
maximum allowable
root gap for fillet joint



Thickness Combined (THC) = $t_1 + t_2$
If root gap is too wide the deck plate or bulkhead may be built-up with weld to achieve a proper gap.
(see fig. 2)

FIG 2:
Build-up of
fillet joint.



NOTE: Weld build-up on the frame is not recommended as it may cause distortion of the frame.

PREHEAT AND INTERPASS TEMPERATURE

To avoid hydrogen cracking when welding MCT Brattberg frames made of carbon, manganese or micro alloy steel
ReL. ° 390N/mm².

IMPORTANT!

To avoid deformation of the frame it is recommended to follow this welding instructions

Putting safety first

Welding Instructions Guide

Mirko Ruiu

A red circular graphic with a gradient, appearing as a semi-circle or a partial circle, located to the right of the author's name.

Welding Instructions Guide:

Technical Manual United States. War Department,1949

Shielded Metal Arc Welding Mirko Ruiiu,2025-09-17

Shielded Metal Arc Welding SMAW also known as stick welding is one of the world s oldest and most widespread techniques and one of the most captivating Behind the spark of the electric arc lies an art built on precision patience and a deep understanding of materials This comprehensive narrative style manual guides the reader step by step from the historical and technical foundations of SMAW to selecting equipment and electrodes and on to advanced techniques for tackling every position and material This isn t a simple list of instructions it s a true learning journey that weaves together theory practice and safety The book is designed both for beginners who want to learn without getting discouraged and for experienced welders who aim to consolidate their professionalism or prepare for recognized certifications With clear language concrete examples and more than 40 000 words of in depth explanations this guide becomes a workshop companion useful for those who weld for passion indispensable for those who do it for a living

Welding Theory and Application United States. War Department,1943

Arc-welding Manual General Electric Company,1928

Anyone Can Weld R. George,2015-02-27

Procedure Handbook of Arc Welding, Design and Practice Lincoln Electric Company,1940

The Big Book of Welding

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Welding Manual United States. Bureau of Reclamation,1953

Manual Training Magazine ,1919

Manual training

and vocational education ,1922 *Manual Training Magazine* Charles Alpheus Bennett,William Thomas Bawden,1921

Instruction Book on Oxy-acetylene Welding & Cutting Prest-O-Lite company, inc., Indianapolis,1915

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 - The Rise of Digital Reading Welding Instructions Guide
 - Advantages of eBooks Over Traditional Books
2. Identifying Welding Instructions Guide
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Welding Instructions Guide
 - User-Friendly Interface
4. Exploring eBook Recommendations from Welding Instructions Guide
 - Personalized Recommendations
 - Welding Instructions Guide User Reviews and Ratings
 - Welding Instructions Guide and Bestseller Lists
5. Accessing Welding Instructions Guide Free and Paid eBooks
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- ePub, PDF, MOBI, and More
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- Welding Instructions Guide Enhanced eBook Features
- 7. Enhancing Your Reading Experience
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 - Highlighting and Note-Taking Welding Instructions Guide
 - Interactive Elements Welding Instructions Guide
- 8. Staying Engaged with Welding Instructions Guide
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Welding Instructions Guide
- 9. Balancing eBooks and Physical Books Welding Instructions Guide
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Welding Instructions Guide
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Welding Instructions Guide
 - Setting Reading Goals Welding Instructions Guide
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Welding Instructions Guide
 - Fact-Checking eBook Content of Welding Instructions Guide
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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