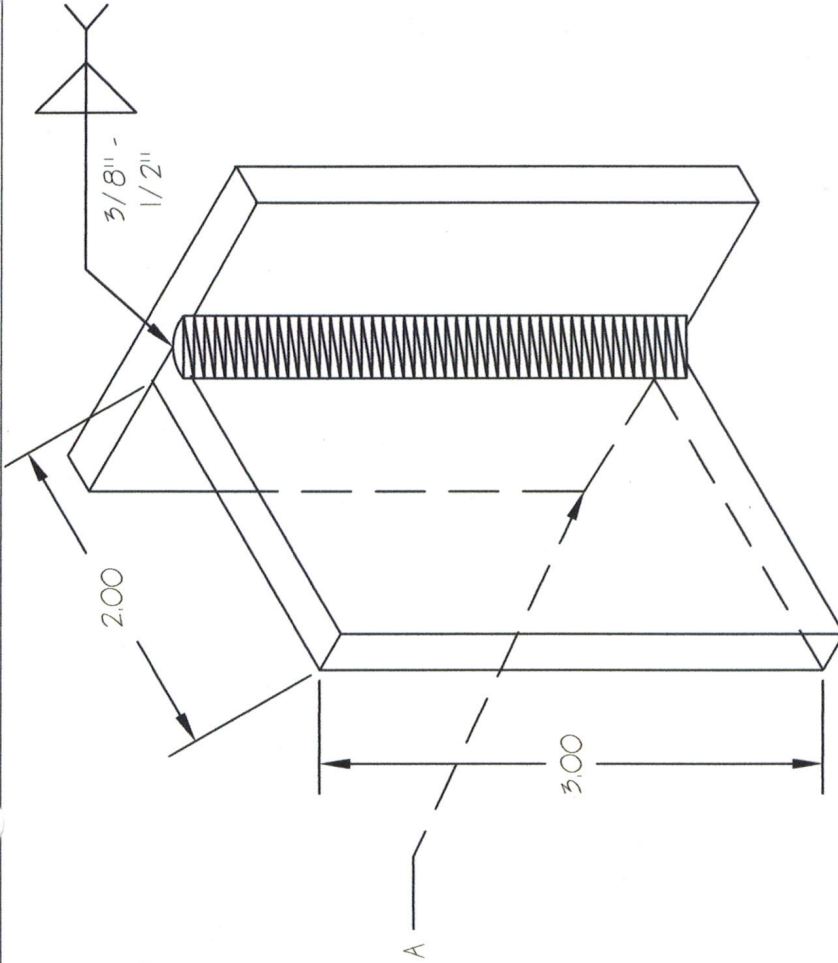


THE MATERIAL IS 3"X2" COUPON STEEL OF VARIOUS THICKNESSES DEPENDING ON THE PROCESS BEING USED. TACK BOTH PIECES TOGETHER ALONG THEIR EDGE AS SHOWN, THEN USING A PIECE OF SCRAP METAL, ATTACH ONE END OF THE SCRAP TO THE COUPON AT POINT "A" AND THE OTHER END TO THE WORK TABLE IN YOUR STATION. THIS WILL RAISE THE PROJECT HIGHER FOR EASE OF WELDING. ONE ROOT PASS WITH LITTLE TO NO MOTION THEN A COVER PASS USING AN APPROVED WEAVE MOTION AND HESITATE ON THE SIDES TO LIMIT UNDERCUT.



1/4" Mild Plate Steel, 1/8" E7018 Amperage range 90A-120A
25 points possible for each weld

10 Gauge Mild Steel and 1/4" Plate Steel .035 E705-6 Adjust wire speed
and voltage according to chart inside machine
25 Points possible for each weld

COMPANY NAME: WCSO METALS II

DRAWING NAME: VERTICAL UP INSIDE CORNER

SCALE: 1:1

NAME: