

Pad of Beads

Directions:

In order to become familiar and comfortable with the techniques required to strike an arc and weld straight, consistent beads, you will practice by creating a pad of beads.

1. Gather all necessary materials to complete a pad of beads. This includes personal safety equipment, base metal, electrode, etc.
2. Prepare your work area by performing the proper safety and set-up procedures.
3. Perform several dry runs of the weld. Have your instructor watch your progress to correct any errors in technique. Remember the work angle is 90° and the travel angle is between 10° - 15° .
4. Once your instructor has approved your dry run technique, practice striking an arc. Utilize both styles of striking an arc (scratching and tapping) and become comfortable with both.
5. Begin your first bead. Remember to watch the puddle as you weld. The size and shape of the puddle will determine what the finished bead will look like.
6. After each pass, cool the base metal and clean the weld before starting the next run. Make sure to have the correct electrode position to provide the appropriate overlap of the previous pass.
7. While running your pad of beads, practice several starts, stops and re-starts to gain experience with these techniques. Remember to clean and brush the crater before restarting the pass.
8. When you have completed your pad of beads, present it your instructor for review. Discuss any trouble or questions you have regarding any of the techniques you practiced.