

2. Forms slags with metal impurities.
3. It stabilizes the arc.
4. Increases deposition of molten metal.
5. Controls depth of penetration.
6. Controls the cooling rate.
7. Adds alloy elements to the joint.

Specifications of electrodes:

An electrode is specified by six digits with profile letter M. These six digits indicate the following matter:

M: It indicates that it is suitable for metal arc welding.

First Digit: First digit may be from 1 to 8, which indicate the type of coating on the electrode.

Second Digit: It denotes the welding position for which electrode is manufactured. It varies from 1 to 6.

Third Digit: It denotes the current to be used for an electrode. It is taken from 0 to 7.

Fourth Digit: Fourth digit is from 1 to 8. Each digit represents the tensile strength of welded joint.

Fifth Digit: It carries any number from 1 to 5. This digit denotes a specific elongation in percentage of the metal deposited.

Sixth Digit: It carries any number from 1 to 5 denotes impact strength of the joint.

WELDING JOINTS

1. **Butt Joint:** In this type of joint, the edges are welded in the same plane with each other. V or U shape is given to the edges to make the joints strong.
2. **Lap Joint:** This type of joint is used in joining two overlapping plates so that the corner of each plate is joined with the surface of other plate. Common types of lap joints are single lap, double lap or offset lap joint.
3. **T-Joint:** When two surfaces are to be welded at right angles, the joint is called T-Joint. The angle between the surfaces is kept 90°.
4. **Corner Joint:** In this joint the edges of two sheets are joined and their surfaces are kept at right angle to each other. Such joints are made in frames, steel boxes etc.
5. **Plug Joint:** Plug Joints are used in holes instead of rivets and bolts.

Kad 3workshop Manual

Ying-Ying Zheng



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Table of Contents Kad 3workshop Manual

1. Understanding the eBook Kad 3workshop Manual
 - The Rise of Digital Reading Kad 3workshop Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Kad 3workshop Manual
 - 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 Kad 3workshop Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Kad 3workshop Manual
 - Personalized Recommendations
 - Kad 3workshop Manual User Reviews and Ratings
 - Kad 3workshop Manual and Bestseller Lists
5. Accessing Kad 3workshop Manual Free and Paid eBooks

- Kad 3workshop Manual Public Domain eBooks
- Kad 3workshop Manual eBook Subscription Services
- Kad 3workshop Manual Budget-Friendly Options
- 6. Navigating Kad 3workshop Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Kad 3workshop Manual Compatibility with Devices
 - Kad 3workshop Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Kad 3workshop Manual
 - Highlighting and Note-Taking Kad 3workshop Manual
 - Interactive Elements Kad 3workshop Manual
- 8. Staying Engaged with Kad 3workshop Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Kad 3workshop Manual
- 9. Balancing eBooks and Physical Books Kad 3workshop Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Kad 3workshop Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Kad 3workshop Manual
 - Setting Reading Goals Kad 3workshop Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Kad 3workshop Manual
 - Fact-Checking eBook Content of Kad 3workshop Manual
 - 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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