

3.3.1 Preparation

The edges of thick metal are prepared for welding by flame cutting, gouging, or machining. Preparation allows the weld to penetrate as deep as required by the engineer or weld designer. A groove joint allows the welder to reach the bottom of the weld joint. The groove angle must be large enough to allow the torch tip or electrode to reach near the bottom of the joint. However, if the groove angle is too large, filler metal and the welder's time are wasted. This increases the cost of making a weld. See Figure 3-12A. A properly designed J-groove or U-groove joint also decreases the groove dimensions while allowing adequate space for welding. See Figure 3-12B.

3.3.2 Joint Alignment

The alignment of a joint before welding is very important. In the shop, the alignment of the weld joint is often referred to as "fit-up." A ragged edge or an edge that is not cut straight is hard to weld. See Figure 3-13. Edges to be welded must be straight and cut to exact size.

Parts of a weldment should be properly aligned and held in position during the welding operation. Tack welding is usually adequate to hold parts during welding. A *tack weld* is a small weld used to hold

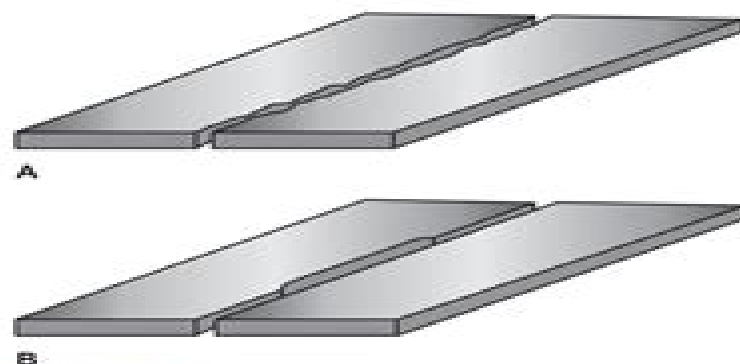


Figure 3-13. Poorly prepared base metal edges. The edges in A are ragged. One edge in B is not cut straight, which changes the width of the joint. Both joints would be difficult to weld.

pieces in alignment. Parts may also be held mechanically during the welding operation because the metal expands, bends, and changes shape when heated. Clamps or other devices, such as jigs and fixtures, are used to hold weldments during welding. See Figure 3-14.

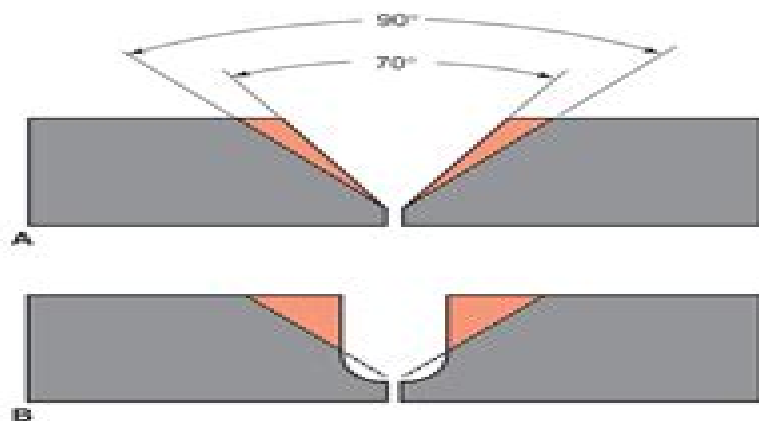


Figure 3-12. Compare the 70° and 90° groove angles. A—A 70° groove angle is cheaper to weld than a 90° groove angle. The shaded area represents an unnecessary cost in filler metal and welder time. B—Look at the U-groove joint. The root of the weld can be reached easily. Little filler metal and welder time are wasted.



Figure 3-14. These various clamps are used to position and hold parts to be welded. (Bessey Tools North America)

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Table of Contents Modern Welding 11th Edition 2013

1. Understanding the eBook Modern Welding 11th Edition 2013
 - The Rise of Digital Reading Modern Welding 11th Edition 2013
 - Advantages of eBooks Over Traditional Books
2. Identifying Modern Welding 11th Edition 2013
 - 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 Modern Welding 11th Edition 2013
 - User-Friendly Interface
4. Exploring eBook Recommendations from Modern Welding 11th Edition 2013
 - Personalized Recommendations
 - Modern Welding 11th Edition 2013 User Reviews and Ratings

- Modern Welding 11th Edition 2013 and Bestseller Lists
- 5. Accessing Modern Welding 11th Edition 2013 Free and Paid eBooks
 - Modern Welding 11th Edition 2013 Public Domain eBooks
 - Modern Welding 11th Edition 2013 eBook Subscription Services
 - Modern Welding 11th Edition 2013 Budget-Friendly Options
- 6. Navigating Modern Welding 11th Edition 2013 eBook Formats
 - ePub, PDF, MOBI, and More
 - Modern Welding 11th Edition 2013 Compatibility with Devices
 - Modern Welding 11th Edition 2013 Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Modern Welding 11th Edition 2013
 - Highlighting and Note-Taking Modern Welding 11th Edition 2013
 - Interactive Elements Modern Welding 11th Edition 2013
- 8. Staying Engaged with Modern Welding 11th Edition 2013
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Modern Welding 11th Edition 2013
- 9. Balancing eBooks and Physical Books Modern Welding 11th Edition 2013
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Modern Welding 11th Edition 2013
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Modern Welding 11th Edition 2013
 - Setting Reading Goals Modern Welding 11th Edition 2013
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Modern Welding 11th Edition 2013
 - Fact-Checking eBook Content of Modern Welding 11th Edition 2013
 - 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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