

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

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