

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

Minjie Lin



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Automobile Digest ,1926 **Foreign Service Regulations of the United States of America** United States.
Department of State. Division of Foreign Service Administration,1941 **Radio-electronics** ,1950 Popular Science
,1952-04 Popular Science gives our readers the information and tools to improve their technology and their world The core
belief that Popular Science and our readers share The future is going to be better and science and technology are the driving
forces that will help make it better **Radio & Television News** ,1951 Some issues Aug 1948 1954 are called Radio
electronic engineering edition and include a separately numbered and paged section Radio electronic engineering issued
separately Aug 1954 May 1955 **Motor Sport** William Boddy,1972 **Ohio Industrial Commission Monitor** ,1974
Current Catalog National Library of Medicine (U.S.), The Soldier's Service Dictionary of English and French Terms
Frank H. Vizetelly,1917 Ohio Monitor ,1974

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