

TEST 2. AWS D1.1 MIG test.

Mild Steel 3/8" plate grade A36. Welding position 1G flat see drawing on next page Fig 4.30. Remove all grease oil and burrs from the plates. Welding Parameters. Amperage 230-250 Volts 26-28 Gas; Argon/CO2. Flow 35-40 cubic feet per hour. Wire feed speed 570-640 Inches per Minute (IPM). Wire. 035" ER70S-6. Ensure first pass penetrates the backing bar and both sides of the bevel. Should take 5-6 passes to fill the joint. Maximum reinforcement 1/8". Make sure backing bar is tight against test plate use 4 tack welds. Backing bar 3" x 1/4" x 7" A36 steel.

Notes: Make sure the **total included angle** in this joint is 45 degrees as shown in the drawing on the next page and that both bevels have 0" root face (feathered edges).