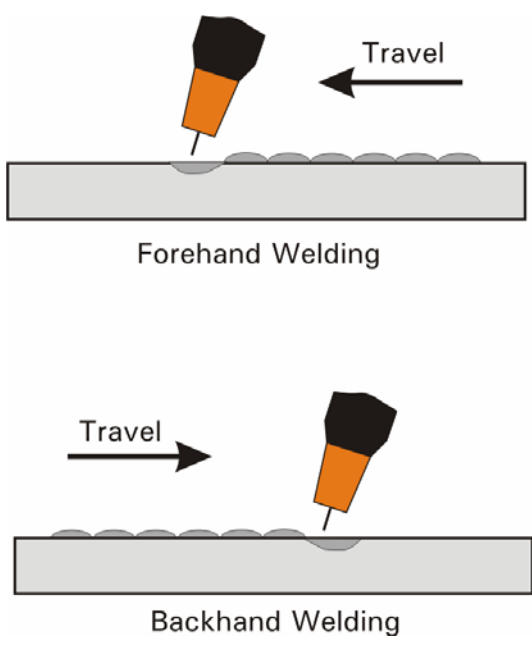
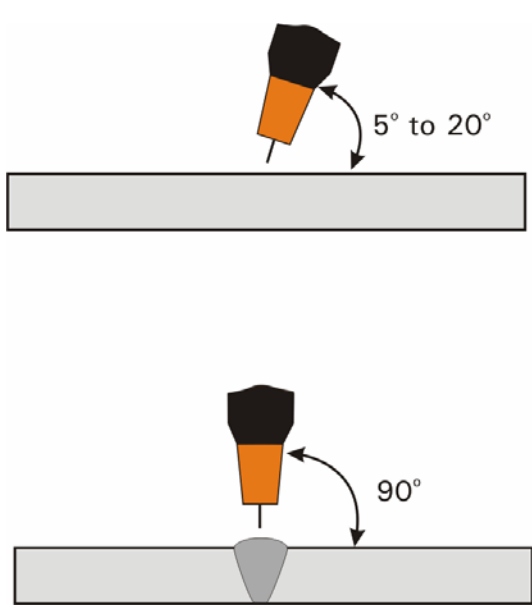
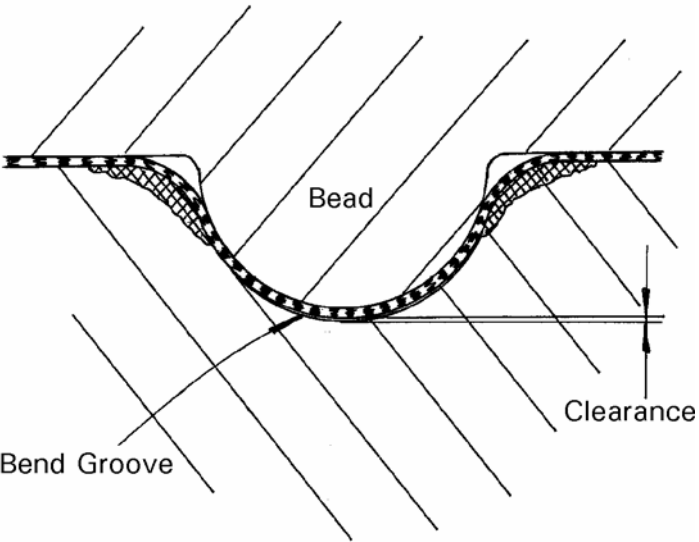
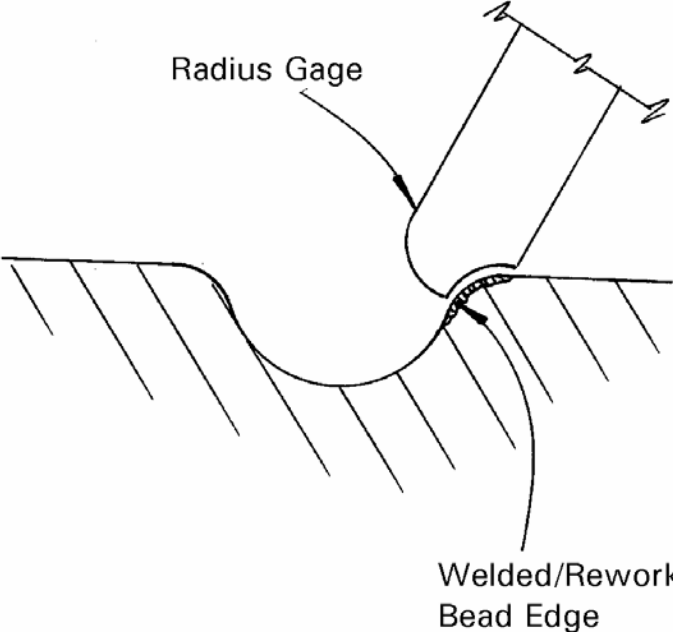


GMAW MIG Welding		Proper positioning and bead movement.	Welding Techniques 4.4	
<b>1</b>	<b>Step 1 and 2</b>	<b>Instructions</b>	<b>Comment</b>	
	 <p>Forehand Welding</p> <p>Backhand Welding</p>	<p>The faster the gun speed the narrower the bead.</p> <p>The forehand method generally results in a higher speed than backhand welding. Travel is the opposite direction from forehand welding. It may be harder to visually follow a badly defined joint with the backhand method.</p>	<p>The forehand method is well suited for thinner materials. Generally better arc stability and less spatter is obtained using the forehand method. The forehand method is always used to weld aluminum.</p> <p>The backhand method is well suited for thicker materials.</p>	
<b>2</b>	<b>Torch angles</b>	<b>Instructions</b>	<b>Comment</b>	
	 <p>5° to 20°</p> <p>90°</p>	<p>Anywhere from 5 to 20 degrees longitudinally is a good angle to align the gun.</p> <p>For flat surfaces it is good practice to stay at 90 degrees perpendicular.</p>	<p>An ideal position that will have good results is created by properly angling the torch.</p> <p>Penetration is maximized by holding the gun correctly.</p>	
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Post-Weld Procedures	Understanding the function of the work-piece after welding.	Draw Die 5.1	
7	Begin Stoning out the grinding marks	Instructions	Comment
		<p>Stone until the correct size is obtained and the radius is smooth.</p> <p>Use radius gauges where possible.</p> <p>Next polish with emery cloth working your way up in grit size.</p>	<p>Stone to size.</p> <p>Polishing will improve material flow.</p>
8	Check finished size and shape	Instructions	Comment
		<p>Use radius gauges if possible.</p>	<p>Make sure you have a true radius.</p>
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