

WELDING POSITIONS

There are three basic welding positions: flat, horizontal, and vertical.

1. The **FLAT POSITION** (Figure 12) is the easiest of the welding positions and is probably the one you have been using thus far. It is best if you can weld in the flat position if at all possible as good results are easier to achieve.

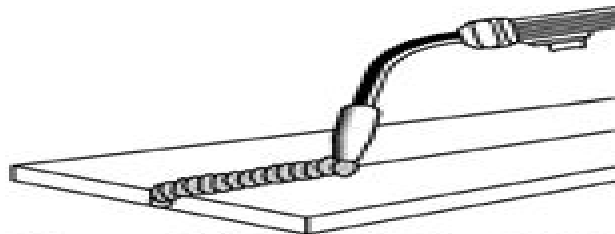


Figure 12. Flat Position Weld

2. The **HORIZONTAL POSITION** (Figure 13) is next in difficulty level. It is performed very much the same as the flat weld except that angle **B** (see **POSITION OF THE GUN TO THE WORK PIECE**, above) is such that the wire, and therefore the arc force, is directed more toward the metal above the weld joint. This is to help prevent the weld puddle from *running* downward while still allowing slow enough travel speed to achieve good penetration. A good starting point for angle **B** is about 30 degrees **DOWN** from being perpendicular to the work piece.

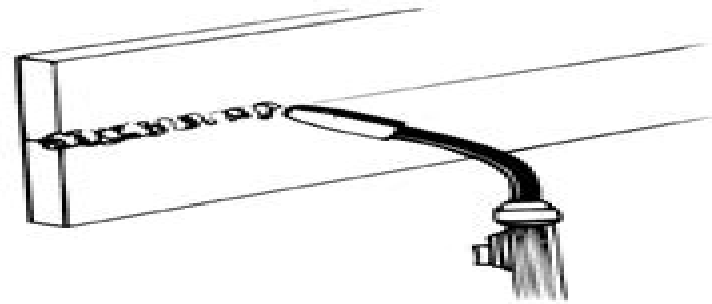


Figure 13. Horizontal Position Weld

3. The **VERTICAL POSITION** (Figure 14) is the next most difficult position. *Pulling* the gun from top to bottom may be easier for many people, but in some instances it can be difficult to prevent the puddle from *running* downward. *Pushing* the gun from bottom to top may provide better puddle control and allow slower rates of travel speed to achieve deeper penetration. When vertical welding, angle **B** (see **POSITION OF GUN TO THE WORK PIECE**, above) is usually always kept at zero, but angle **A** will generally range from 45 to 60 degrees to provide better puddle control.

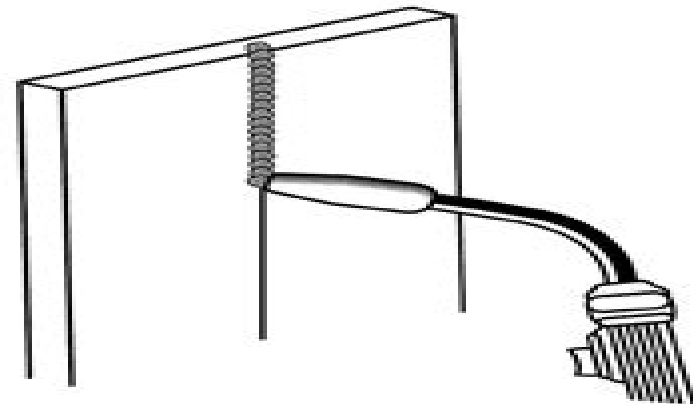


Figure 14. Vertical Position Weld

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