

# Effective Stainless Steel Pipe Welding

## 1. Preparation & Technique



**Select Technique: GTAW**  
(Gas Tungsten Arc Welding)  
- Precision & Control



**Material Preparation:**  
- Clean pipes thoroughly  
(Oil, grease, oxides)  
- Use Acetone or SS Brush  
(Prevent contamination)



**Edge Preparation:**  
- Bevel edges (V-groove)  
(For full penetration)

## 2. Equipment Setup



**Power Source:**  
- Suitable Voltage  
- Suitable Amperage



**Shielding Gas:**  
- Argon-based  
(Prevent oxidation)



**Filler Metals:**  
- Low-carbon (ER308L/ER316L)  
(Minimize corrosion risks)

## 3. Welding Process



**Maintain Consistent:**  
- Travel Speed  
- Travel Angle



**Back Purging:**  
- Inert gas inside pipe  
(Avoid sugaring)



**Tack-Weld Frequently:**  
- Manage heat  
- Prevent distortion



**Execute Passes Methodically:**  
- Root, Filler, Cap



**Interpass Temperature:**  
- Below 300°F  
(Avoid warping)

# Welding And Pipe Study Guide

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