

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

**United States. Division of Vocational
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