

WELDING TECHNIQUES

MAKING VERTICAL UP WELDS

Use 5/64" (2.0mm) size and less.

NR-202	NR-203M
NR-203MP	NR-203 Nickel (1%)
NR-211-MP	NR-212
NR-232	NR-233

Smaller sizes, 5/64" and less are recommended for all position welding.

When welding out-of-position, don't whip, break the arc, move out of the puddle or move too fast in any direction. Use WFS in the low portion of the range. General techniques are illustrated below. Experience will show how much hesitation and upward step is required for high quality welds.

Generally, keep the wire nearly perpendicular to the joint as illustrated. The maximum angle above perpendicular may be required if porosity becomes a problem.

