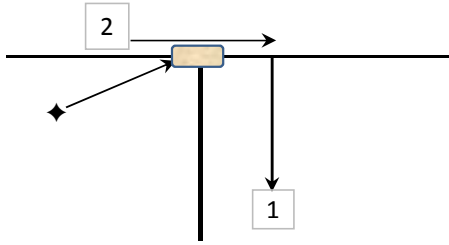


### 1 - T-Joint



#### 1st Side

1st Weld "1"

◆ - To grind groove- 2" in length

2nd- Weld "2"

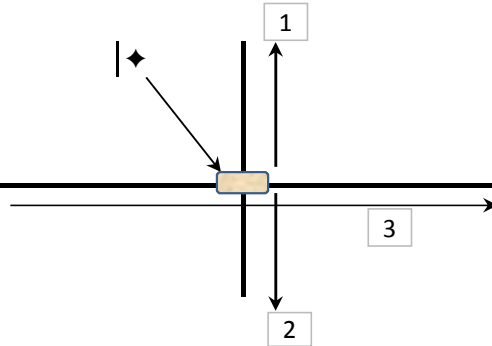
2nd Side- after backgouging in U- Shape

1st Weld - "1"

◆ - To grind groove- 2" in length

2nd Weld - "2"

### 2 - Cross- Joint



#### 1st Side

1st Weld "1" / 2nd- Weld "2"

◆ - To grind groove

Proceed to weld 3

#### 2nd Side

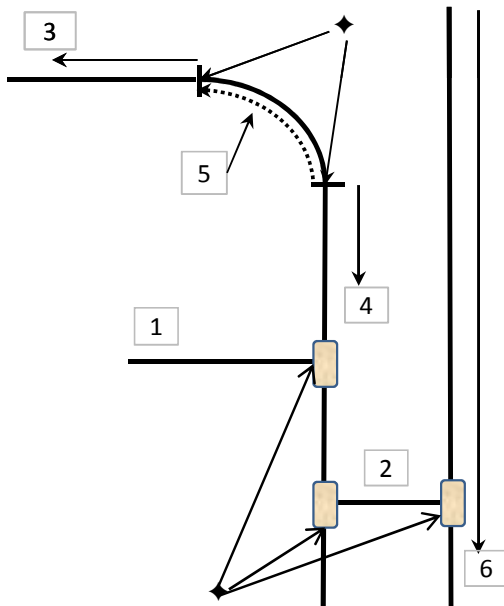
Backgouge to create U-groove and grind clean

1st Weld "1" / 2nd- Weld "2"

◆ - To grind groove

Proceed to weld 3

### 3 - Radius + T-Joint



#### 1st-Side

Weld 1, 2; followed by 3, 4( starting from radius ends)

◆ - To grind groove- all start points to create spoon-like shape

Proceed to weld "5" with FCAW and blend smoothly

Proceed to weld "6"

#### 2nd Side

Backgouge to create U-groove and grind clean

Weld 1, 2; followed by 3, 4( starting from radius ends)

◆ - To grind groove- all start points to create spoon-like shape

Proceed to weld "5" with FCAW and blend smoothly

Proceed to weld "6"