Welding

General

- You control slag deposition in 3 ways…travel speed, arc length, and angle of electrode. Experiment with all 3.

6013 do's & don't

- Higher amp for T-joints then for flat (2 surfaces)
- Work on clean metal. It's not a deep penetration rod and therefore does not burn though surface contaminants very well.
- In T-joint hold rot 30-35 degrees from horizontal plane, to make sure that enough is deposit on the vertical plane. Gravity will take care of horizontal plane
- Having a slag stringer in the start of a 6013 bead is very common. What you are seeing is the heavy flux on top of the weld pool, and not molten metal. Getting a slightly slower start to the weld bead will solve this problem. A little hesitation before moving the rod will give the puddle time to bridge between both surfaces and solve this problem.
- Try pausing when you first strike up so that a puddle can form and slow the travel speed down a little for the first inch
- holding too long of an arc length, and it is difficult to manipulate the metal where to go. Put the rod right into the crack

Alternatives

- 6010
- 7018 (7016)