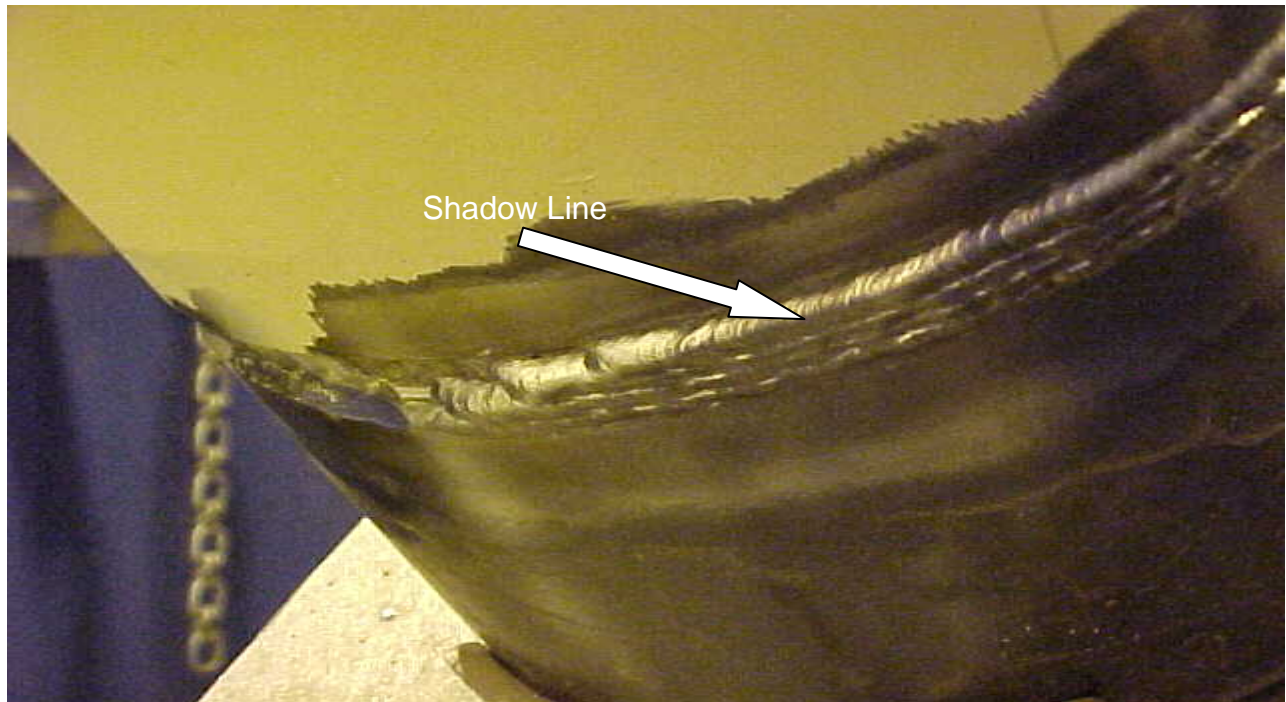


How to Run Straight Stringer Beads and Setting Amperages using E7018, E8018 and E9018 Series Electrodes

Textbook theory is to run stringer beads approximately 1/3 bead over lap, but another way to run nice and straight stringer beads with E7018, E8018 and E9018 series electrodes is using a technique called welding by shadow on pipe; the second pass casts a shadow exactly at the highest part of the first stringer bead which is called the crown. This shadow is a perfect straight line!



Stringer Bead Technique: Run the puddle edge along the line formed where the light from the arc disappears under the first pass and continue with each following pass. This technique can be used on pipe in the 2g, 5g, and 6g positions.

Amperage Technique: To get an approximate base line setting of the amperages using E7018, E8018 and E9018 series electrodes take the diameter of the electrode and change the fraction into a three number decimal. (i.e. $3/32'' = .093$ amps, $1/8'' = .125$ amps, $5/32'' = .156$ amps, $1/4'' = .250$ amps)

Using these techniques will not only help the appearance of the weld but improve the chance of trapping slag if proper cleaning is utilized.

These are only recommendations; you should always read and understand the procedure specifications that are unique to each job site.