

Module Overview

This module explains how to prepare SMAW equipment for open-root V-groove pipe welds. It also covers how to make open-root V-groove pipe welds in all positions using SMAW equipment.

Prerequisites

Prior to training with this module, it is recommended that the trainee shall have successfully completed the following: *Core Curriculum; Welding Level One; and Welding Level Two.*

Objectives

Upon completion of this module, the trainee will be able to do the following:

1. Prepare SMAW equipment for open-root V-groove pipe welds.
2. Identify and explain open-root V-groove pipe weld techniques with SMAW equipment.
3. Perform open-root V-groove pipe welds in the following positions using SMAW equipment:
 - 1G-ROTATED
 - 2G
 - 5G
 - 6G

Performance Tasks

Under the supervision of the instructor, the trainee should be able to do the following:

1. Prepare SMAW equipment for open-root pipe welds.
2. Make pipe welds in the 1G-ROTATED position.
3. Make pipe welds in the 2G position.
4. Make pipe welds in the 5G position.
5. Make pipe welds in the 6G position.

Materials and Equipment List

Markers/chalk
Pencils and scratch paper
Whiteboard/chalkboard
Welding 3 PowerPoint® Presentation Slides
(ISBN 978-0-13-214725-5)
Multimedia projector and screen
Desktop or laptop computer
Appropriate personal protective equipment
A legal safety harness with lanyards
SMAW welding equipment
A supply of $\frac{1}{8}$ " E6010 and $\frac{1}{8}$ " or $\frac{3}{16}$ "
E7018 electrodes
Rod holder
Electrode oven
A supply of 3" to 12" diameter Schedule 40 or
Schedule 80 carbon steel pipe for coupons
Cleaning materials for cleaning coupons
MSDS for each cleaning material used
Welding bench with arm for position work

Adjustable pipe stands with rollers
Portable grinders with extra grinding discs
Fully-charged fire extinguishers for the labs
Welding curtains or shields
Bevel gauges
Hi-Lo gauges
Levels
Framing squares
Soapstone
Tape measures
Precision measurement devices
(micrometers and calipers)
Pliers
Half-round bastard files
Wire brushes
Chipping hammers
Workpiece clamps
Module Examinations*
Performance Profile Sheets*

*Located in the Test Booklet.

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29301-16 SMAW Open-Root Pipe Welds Trainee Guide

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