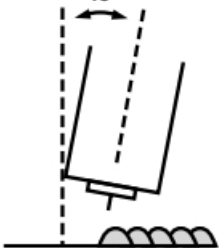


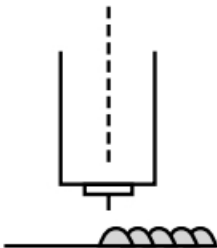
Push

10°



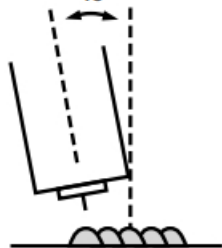
Electrode directed  
ahead of bead

Perpendicular



Drag

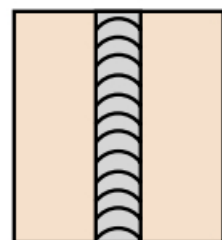
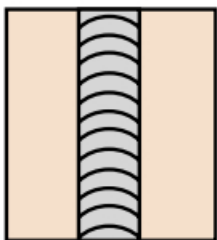
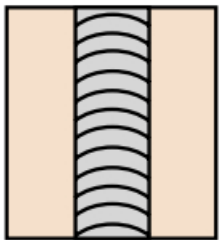
10°



Electrode pointed  
back into bead



Direction Of Welding



(A) Push Technique

(B) Gun Perpendicular

(C) Drag (Pull) Technique

Effect of Electrode Position and Welding Technique