

Introduction to Welding and Oxyfuel

Chapter 1

History of Welding

Chapter 2

Industrial Welding

Chapter 3

Steel and Other Metals

Chapter 4

Basic Joints and Welds

Chapter 5

Gas Welding

Chapter 6

Flame Cutting Principles

Chapter 7

Flame Cutting Practice: Jobs 7-J1–J3

Chapter 8

Gas Welding Practice: Jobs 8-J1–J38

Chapter 9

Braze Welding and Advanced Gas Welding Practice: Jobs 9-J39–J49

Chapter 10

Soldering and Brazing Principles and Practice: Jobs 10-J54–J51

History of Welding

Overview

You are about to begin the learning process of preparing yourself for a position in one of the fastest growing industries in the world of work—the *welding industry*.

Welding is the joining together of two pieces of metal by heating to a temperature high enough to cause softening or melting, with or without the application of pressure, and with or without the use of filler metal. Any filler metal used has either a melting point approximately the same as the metals being joined or a melting point that is below these metals but above 800 degrees Fahrenheit (°F).

New methods, new applications, and new systems have been developed in the last several years. Continuing research makes welding a dynamic leader in industrial processes. The industry has made tremendous progress in a short period of time. Furthermore, it has made a major contribution toward raising the standard of living of the American people. By simplifying and speeding up industrial processes and making it possible to develop environmentally sound industries like wind and solar power, hybrid power vehicles, plants to produce organic fuels, and continued development in nuclear, fossil fuels along with continued space exploration and utilization, it has increased the world's supply of goods, Fig. 1.1.

Chapter Objectives

After completing this chapter, you will be able to:

- 1-1** Explain the history of metalworking and welding.
- 1-2** Explain the development of modern welding.
- 1-3** Give details of the mission of welding in the industrial process.
- 1-4** Describe the diverse welding processes.
- 1-5** List the various welding occupations.
- 1-6** Define welder qualifications and characteristics.
- 1-7** Express the duties and responsibilities of a welder.
- 1-8** Recognize welder safety and working conditions.
- 1-9** Identify trade associations and what responsibility they have in the welding industry.
- 1-10** Establish goals to keep you up to date in the field.



Fig. 1-1 Use of natural energy sources (green energy) such as solar, wind turbines, and bio-fuels like ethanol are getting a tremendous amount of interest in the way of research, development, and real applications. As they continue to develop, other issues will need to be dealt with, such as ROI. Welding plays a very important role in the manufacture of these green energy sources. Source: Top photo: © Jim West/The Image Works; middle photo: © David H. Wells/The Image Works; bottom photo: © Scott Olson/Getty.

Welding is usually the best method to use when fastening metal. If you want to build something made of metal, you can fasten the parts by using screws or rivets, bending the parts, or even gluing the parts. However, a quality, long-lasting, attractive, safe product is best fabricated by using one of the many types of prevailing welding processes.

The History of Metalworking

Metalworking began when primitive people found that they could shape rocks by chipping them with other rocks. The first metal to be worked was probably pure copper because it is a soft, ductile metal that was widely available. **Ductile** means easily hammered, bent, or drawn into a new shape or form. Excavations in Egypt and in what is now the United States indicate the use of copper as early as 4000 B.C. and before 2000 B.C., respectively. More than 4,000 years ago copper mines on the peninsula of Sinai and the island of Cyprus were worked. Welding began more than 3,000 years ago when hot or cold metals were hammered to obtain a forge weld. Forged metals, bronze and iron, are mentioned in the Old Testament.

Archaeologists have determined that bronze was developed sometime between 3000 and 2000 B.C. Iron became known to Europe about 1000 B.C., several thousand years after the use of copper. About 1300 B.C. the Philistines had four iron furnaces and a factory for producing swords, chisels, daggers, and spearheads. The Egyptians began to make iron tools and weapons during the period of 900 to 850 B.C. After 800 B.C. iron replaced bronze as the metal used in the manufacture of utensils, armor, and other practical applications. A welded iron headrest for Tutankhamen (King Tut) was crafted around 1350 B.C.

The famous Damascus swords and daggers were made in Syria about 1300 B.C. These were sought after because of their strength and toughness. Their keen edge was likely capable of severing heavy iron spears or cutting the most delicate fabric floating in the air. The swords were made by forge-welding iron bars of different degrees of hardness, drawing them down, and repeating the process many times.

The working of metals—copper, bronze, silver, gold, and iron—followed one another in the great ancient civilizations. By the time of the Roman Empire, the use of iron was common in Europe, the Near East, and the Far East. The Chinese developed the ability to make steel from wrought iron in A.D. 589. The Belgians were responsible for most of the progress made in Europe,

due to the high degree of craftsmanship developed by their workers. By the eighth century the Japanese manufactured steel by repeated welding and forging and controlled the amount of carbon in steel by the use of fluxes. They produced the famous Samurai sword with a blade of excellent quality and superior workmanship.

The blast furnace was developed for melting iron about the years A.D. 1000 to 1200. One such furnace was in the Province of Catalonia in Spain. The fourteenth and fifteenth centuries saw great improvements in the design of blast furnaces. The first cast iron cannon was produced in the early 1600s.

About the middle of the eighteenth century, a series of inventions in England revolutionized the methods of industry and brought on what later came to be known as the Industrial Revolution. Our present factory system of mass production was introduced. An American, Eli Whitney, developed the idea of interchanging parts in the manufacture of arms. By the beginning of the nineteenth century, the working of iron with the use of dies and molds became commonplace. Early in the twentieth century, Henry Ford was involved in developing the assembly line method for manufacturing automobiles.

Early Developments in Welding

At the beginning of the nineteenth century, Edmund Davy discovered **acetylene**, a gas that was later used in oxyacetylene welding, heating, and cutting. The electric arc was first discovered by Sir Humphry Davy in 1801 while he was conducting experiments in electricity. He was concerned primarily with the possibilities of the use of the arc for illumination. By 1809 he had demonstrated that it was possible to maintain a high voltage arc for varying periods of time. By the middle of the nineteenth century, workable electrical-generating devices were invented and developed on a practical basis. These inventions were the forerunner of the present arc welding process.

The first documented instance of fusion welding was done by Auguste de Meritens in 1881. He welded lead battery plates together with a carbon electrode. Two of his pupils, N. Benardos and S. Olszewski, saw the possibilities of this discovery and experimented with the arc powered by batteries that were charged from high voltage dynamos. After four years of work, they were issued a British patent for a welding process using carbon electrodes and an electric power source. Applications of the process included the fusion welding of metals, the cutting of metals, and the punching of holes in metal. Although they experimented with solid and hollow carbon rods filled with

powdered metals, the solid electrodes proved more successful. Repair welding was the primary goal of the inventors.

Bare metal electrode welding was introduced in 1888 by N. G. Slavianoff, a Russian. His discovery was first recognized in western Europe in 1892. C. L. Coffin was one of the pioneers of the welding industry in the United States. In 1889 he received a patent on the equipment and process for flash-butt welding. In 1890 he received additional patents for spot-welding equipment. In 1892, working without knowledge of Slavianoff's work, he received a patent for the bare metal electrode *arc welding* process. By the turn of the century welding was a common method of repair. At this time welding was given added impetus by the development of the first commercial *oxyacetylene welding* torch by two Frenchmen, Foresche and Picard. Bare electrode welding became the prevailing electric arc welding method used in the United States until about 1920.

Bare metal electrode welding was handicapped because the welds produced by these electrodes were not as strong as the metal being welded and the welding arc was very unstable. In 1907 Kjellberg, a Swedish engineer, received a patent covering the electrode-coating process. The coating was thin and acted only as a stabilizer of the arc rather than as a purifier of the weld metal. It produced welds that were little better than those made with bare electrodes. In 1912 Kjellberg received another patent for an electrode with a heavier coating made of asbestos with a binder of sodium silicate. See Fig. 1-2. Benardos patented a process in 1908 that has come into popular use in the past few decades. This is the **electroslag** process of welding thick plates in one pass.

Welding technology and its industrial application progressed rather slowly until World War I. Prior to that time it was used chiefly as a means of maintenance and repair. The demands of the war for an increased flow of goods called for improved methods of fabrication.

ABOUT WELDING

Shipbuilding

Through 1945, some 5,171 vessels of all types were constructed to American Bureau of Shipping standards during the Maritime Commission wartime shipbuilding program. At this time in shipbuilding history, welding was replacing riveting as the main method of assembly.



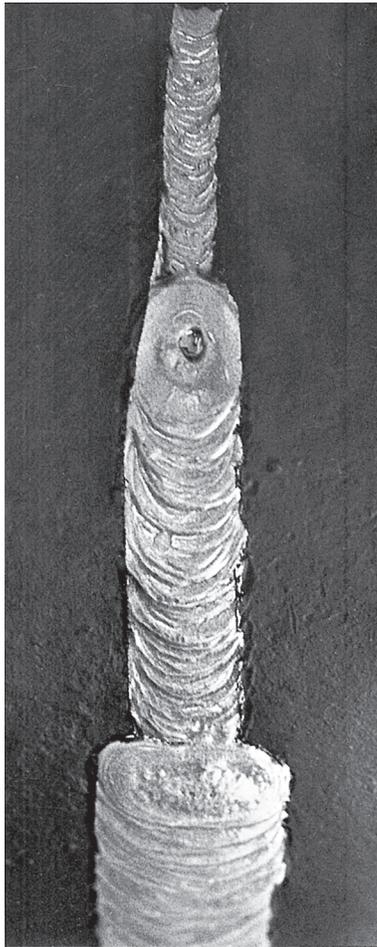


Fig. 1-2 The ability to make multipass welds such as this one, on plate and pipe, led to the growth of the industry. Welds are sound and have uniform appearance.

At the end of World War I, welding was widely accepted. Research on coated electrodes through the 1920s resulted in electrode coatings and improved core wire. This significant development was the main reason for the rapid advancement of the stick welding process. This term has now been superseded by the term *shielded metal arc welding* (SMAW). The development of X-raying goods made it possible to examine the internal soundness of welded joints which indicated a need for improved methods of fabrication.

The Development of Modern Welding

During the postwar period the design of welding machines changed very little. Since welding was first done with direct current (d.c.) from battery banks, it was only natural that as welding machines were developed, they would be d.c. machines. In the late 1920s and during the 1930s, considerable research was carried on with

alternating current (a.c.) for welding. The use of a.c. welding machines increased through the early 1930s. One of the first high frequency, stabilized a.c. industrial welding machines was introduced in 1936 by the Miller Electric Manufacturing Company. The a.c. welding machines have since become popular because of the high rate of metal deposition and the absence of arc blow.

World War II spurred the development of inert gas welding, thus making it possible to produce welds of high purity and critical application. A patent was issued in 1930 to Hobart and Devers for the use of the electric arc within an inert gas atmosphere. The process was not well received by industry because of the high cost of argon and helium and the lack of suitable torch equipment.

SHOP TALK



Beams

Beams used in bridges must be welded on both sides. In automated systems, a second station can handle the reverse side, or a turnover station is used to get the beam back to be sent through a second time.

Russell Merideth, an engineer for the Northrop Aircraft Company, was faced with the task of finding an improved means of welding aluminum and magnesium in the inert atmosphere. Because of a high burnoff rate, the magnesium procedure was replaced by a tungsten electrode, and a patent was issued in 1942. Later in 1942 the Linde Company obtained a license to develop the *gas tungsten arc welding* (GTAW) [or *tungsten inert gas* (TIG)] process, also known as HELIARC, used today, Fig. 1-3. The company perfected a water-cooled torch capable of high amperage.

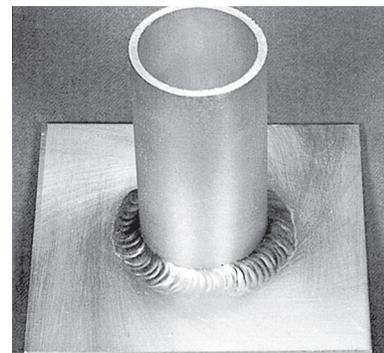


Fig. 1-3 An aluminum weld made using the TIG process. The welding of aluminum is no longer a problem and can be done with the same ease as that of steel.

GTAW welding was first done with rotating d.c. welding machines. Later, a.c. units with built-in high frequency were developed. In about 1950, selenium rectifier type d.c. welding machines came into use, and a.c.-d.c. rectifier welding machines with built-in frequency for GTAW welding became available in the 1950s. Since that time the Miller Electric Manufacturing Company has developed the Miller controlled-wave a.c. welder for critical welds on aircraft and missiles. Now many manufacturers of welding machines produce square-wave a.c. machines.

The use of aluminum and magnesium increased at a rapid rate as a result of (1) the development of GTAW welding, and (2) the desirable characteristics of reduced weight and resistance to corrosion. As the size of weldments increased, thicker materials were employed in their construction. It was found that for aluminum thicknesses above 1/4 inch, GTAW welding required preheating. Since this was costly and highly impractical for large weldments, a number of welding equipment manufacturers engaged in the search for another welding process.

In 1948 the U.S. patent office issued a patent for the **gas metal arc welding (GMAW)** process. The GMAW term superseded the earlier terms of *metal inert gas (MIG)* and *metal active gas (MAG)*.

The GMAW process, Fig. 1-4, concentrates high heat at a focal point, producing deep penetration, a narrow bead width, a small heat-affected zone, and faster welding speeds resulting in less warpage and distortion of the welded joint and minimum post-weld cleaning. The use of GMAW has increased very rapidly; it is now used in virtually all industries. A GMAW or similar process is responsible for over 70 percent of welds being performed today. In the early 1950s the gas shielded flux cored arc welding (FCAW) process was developed. It was referred to as “dual shield” as it had a flux but also required external gas shielding. Late in the 1950s self-shielded flux cored wires were introduced. And in the early 1970s

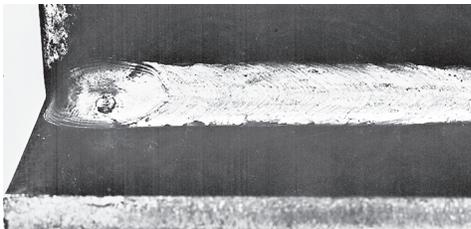


Fig. 1-4 A fillet weld made with flux cored arc welding.
Source: St. Louis Car. Co.

all position flux cored wires became available. Metal cored wires came along shortly after this. The solid wire, metal cored wire and flux cored wire use nearly the same equipment; however, since flux cored wires produce a slag that covers the entire weld, it is considered a separate process.

During the 1980s and continuing today, rapid changes are evolving in the welding industry as engineers devise more advanced filler metal formulas to improve arc performance and weld quality on even the most exotic of materials. Even though our history is vague in the areas of welding and filler metal development, it has shown that advancements are inevitable and will continue, such as exotic multiple gas mixes, state-of-the-art electrodes, onboard computers, hybrid processes, and robotic welding. Some processes were developed for limited applications and are used to fill a particular need. Other methods are evolving that may significantly change the way welds will be made in the future.

The following processes involve the use of the electric arc:

- Arc spot welding
- Atomic-hydrogen welding
- Electro-gas
- Plasma arc welding
- Stud welding
- Submerged arc welding
- Underwater arc welding

Other specialized processes include

- Cold welding
- Electron beam welding
- Explosive welding
- Forge welding
- Friction welding
- Friction stir welding
- Laser welding
- Oxyhydrogen welding
- Thermit welding
- Ultrasonic welding
- Welding of plastics

Today there are over 90 welding processes in use. The demands of industry in the future will force new and improved developments in machines, gases, torches, electrodes, procedures, and technology. The shipbuilding, space, and nuclear industries conduct constant research for new metals, which in turn spurs research in welding. For example, the ability to join metals with nonmetallic materials is the subject of much effort. As industry expands and improves its

technology, new welding processes will play an indispensable part in progress.

Currently, five welding associations provide guidance and standards related to the welding industry.

- American National Standards Institute (ANSI)
- American Petroleum Institute (API)
- American Society of Mechanical Engineers (ASME)
- American Welding Society (AWS)
- American Bureau of Shipping (ABS)

Welding as an Occupation

A student needs to learn all phases of the trade. Welding, reading drawings, math, and computer knowledge will secure a successful career. Many qualified welders are certified by the AWS, ASME, and API. The tests are difficult and require many hours of practice.

Because welders hold key positions in the major industries, they are important to the economic welfare of our country. Without welding, the metal industry would be seriously restricted; many of the scientific feats of the past and the future would be impossible. As long as there are metal products, welders will be needed to fabricate and repair them.



Fig. 1-5 Welding is generally considered a nontraditional occupation for women. However, it can be a very lucrative and in-demand skill for those women choosing this career path. A procedure is being used setting up a plasma arc gouging operation. Source: © Anderson Ross/Iconica/Getty.

Keep in mind that the field of welding can offer you prestige and security. It can offer you a future of continuous employment with steady advancement at wages that are equal to other skilled trades and are better than average. It can offer you employment in practically any industry you choose and travel to all parts of the world. It is an expanding industry, and your chances for advancement are excellent. Welders have the opportunity to participate in many phases of industrial processes, thus giving them the broad knowledge of the field necessary for advancement to supervisory or technical positions.

Industrial Welding Applications

Welding is not a simple operation. The more than 90 different welding processes are divided into three major types: arc, gas, and resistance welding. A number of other types such as induction, forge, thermit, flow welding, and brazing are used to a somewhat lesser extent.

Resistance welding includes spot welding, seam welding, flash welding, projection welding, and other similar processes that are performed on machines. These welding areas are not the subject of this text. Because of the specialized nature of the machines, operators are usually taught on the job. They are semiskilled workers



JOB TIP

Job Hunting

Looking for a job is a job! When you begin, make a list of what you plan to do in the next week. Assess what kind of job you want. As you complete items on your list, you not only will be closer to your goal, but you also will be in control of the job-hunting process and will be less stressed.

Welding is gender friendly, Fig. 1-5. Thousands of women are employed throughout the industry. Many women find the work highly satisfying and are paid well at a rate equivalent to that of men.

Welding is done in every civilized country in the world. You may wish to work in the oil fields of the Near East or in our own country. You may wish to work in some jungle area of South America or Africa, constructing buildings, power plants, pipelines, or bridges. Our many military installations throughout the world offer jobs for civilian workers. Employment opportunities for welders are plentiful in all parts of the United States.



Fig. 1-6 Welding in the vertical position. Source: Miller Electric Mfg. Co.



Fig. 1-7 Instructor observing students practicing for a 5G position pipe weld test. The welder is working out of the overhead position on the pipe and getting into the vertical position. The progression of the weld is uphill. The flux cored arc welding process is being used and is being applied in a semi-automatic fashion. Source: Miller Electric Mfg. Co.

who do not need specific hands-on welding skills. The arc and gas welding processes will be extensively covered later in this text.

In a sense, welders are both artists and scientists. Arc and gas welders have almost complete control of the process. Much of their work demands manipulative skill and independent judgment that can be gained only through training and a wide variety of job experience. They must know the properties of the metals they weld; which weld process to use; and how to plan, measure, and fabricate their work. They must use visualization skills and be precise, logical, and able to use their heads as well as their hands. Most welders are expected to be able to weld in the vertical and overhead positions, Figs. 1-6 and 1-7, as well as in the flat and horizontal positions.

Gas welders may specialize in oxyacetylene or GTAW processes. Some welders are skilled in all the processes. You should acquire competence in shielded metal arc SMAW, GTAW, and GMAW processes for both plates and pipes.

Qualifications and Personal Characteristics

The standards are high in welding. In doing work in which lives may depend on the quality of the welding—high-rise buildings, bridges, tanks and pressure vessels of all kinds, aircraft, spacecraft, and pipelines—welders must be certified for their ability to do the work, and their work is inspected, Figs. 1-8 and 1-9. Welders are required to pass periodic qualification tests established by various code authorities, insurance companies, the military, and other governmental inspection agencies.



Fig. 1-8 Using a method of weld inspection known as magnetic-particle testing in building construction. Weld testing and inspection give proof of the soundness of welds. Source: Circlesafe Aerosol/Circle Systems, Inc.

Certifications are issued according to the kind and gauge of metal and the specific welding process, technique, or procedure used. Some welders hold several different certifications simultaneously.

The welder must perform certain basic tasks and possess certain technical information in order to perform the welding operation. In making a gas weld, the welder attaches the proper tip to the torch and adjusts the welding regulators for the proper volume and pressure of the gases. The welder must also regulate the flame according to the needs of the job.



Fig. 1-9 Workers using a crane to lift a cask filled with highly radioactive fuel bundles at a Hanford, Washington, nuclear facility. The construction of this type of vessel relies heavily upon welding. Source: AP Photo/U.S. Department of Energy, The Monroe Evening News.

For electric arc welding, the welder must be able to regulate the welding machine for the proper welding current and select the proper electrode size and type, as well as the right shielding gas.

Welding requires a steady hand. The welder must hold the torch or electrode at the proper angle, a uniform distance from the work, and move it along the line of weld at a uniform speed.

During the welding process, the welder should use visualization skills to form a mental picture of how the weld will be created. Although much of the work is single pass, welds made on heavy material often require a number of passes side by side and in layers according to the specified weld procedure.

Welders must also be able to cut metals with the oxy-acetylene cutting torch and with the various cutting procedures involving the plasma arc cutting machine. Flame cutting is often the only practical method for cutting parts or repairing steel plate and pipe. **Plasma arc cutting** is used to cut all types of metals. Proper



Fig. 1-10 A large amount of art metalwork is done with welding processes. Source: Enrique Vega.

use of an electric or pneumatic grinder will save many hours in the welding process.

The master welder is a master craftsman, Fig. 1-10. Such a person is able to weld all the steels and their alloys, as well as nickel, aluminum, tantalum, titanium, zirconium, and their alloys and claddings. From heavy pressure vessels requiring 4-inch plate to the delicate welding of silver and gold, the welds are of the highest quality and can be depended upon to meet the requirements of the job.

The following welding occupations require a high school education:

- Welding operator
- Welder fitter
- Combination welder
- Master welder
- Welding supervisor
- Welding analyst
- Inspector
- Welding foreman
- Welding superintendent
- Equipment sales
- Sales demonstrator
- Sales troubleshooter
- Welding instructor
- Robotics welder operator
- Job or fabrication shop owner

Certain welding occupations also require a college education:

- Welding engineer (metallurgical)
- Welding development engineer
- Welding research engineer
- Welding engineer
- Technical editor
- Welding professor



SHOP TALK

Medical Alert

The technology of medical heart pacemakers continues to change. Some pacemakers are less likely to be prone to interference by electromagnetic fields. People who weld and have pacemakers are safer if there are other people nearby to help if they have problems. Waiting 10 seconds between each weld may be a good strategy for those with pacemakers.



Fig. 1-11 Welders in the construction industries are called upon to weld in many unusual positions. Here, a welder and helper are making an attachment to a building beam in the overhead position. The shielded metal arc welding process is being used and is being applied in the typical manual fashion. Note the safety gear and fall protection devices.
Source: © Vicki Silbert/PhotoEdit.

- Certified welding inspector (AWS/CWI)
- Corporation executive
- Owner of welding business
- Sales engineer

Many people in the welding occupations listed entered the industry as welders and were able to improve their positions by attending evening classes at a university or community college.

Safety and Working Conditions

Welders work on many kinds of jobs in almost any environment. They may do light or heavy welding, indoors or outdoors, in spacious surroundings or cramped quarters. Often they work in awkward positions in boiler shops, shipyards, tanks, and piping systems. The work may be extremely noisy (hearing protection will be necessary), and welders may have to work on scaffolds high off the ground (necessitating the use of a safety harness), Fig. 1-11. On some jobs there may be considerable lifting, tugging, and pushing as equipment and materials are placed in position.

A large number of unsafe situations must be of concern to the welder who is conscious of the need to work in a safe environment. Very often accidents are caused as a result of some small, relatively unimportant condition. Extremely dangerous hazards usually get the attention of the welder and are, therefore, rarely a cause of accidents.

Job hazards may include fire danger, burns, “sunburn” from electric arcs, noxious fumes from materials vaporized at high temperatures, eyestrain, welders flash, and electric shock. These hazards can be minimized or eliminated by the use of the proper protective clothing and safety shoes, welding hood, face shields, goggles, respiratory equipment, and adequate ventilation. When performing jobs, welders always take precautionary measures for their own safety and the safety of others in the area.

You are encouraged to study the various safety practices and regulations presented in this text. Safety precautions related to specific processes are presented in the principle chapters (Chapters 1–6, 10, 11, 12, 18, 21, 25–32). Safe welding technique and the safe use of equipment are given in the practice chapters (Chapters 7–10, 13–17, 19, 20, 22–24). Before you begin to practice welding, you should read Chapter 32, Safety, which summarizes the safety measures described elsewhere and presents the precautions to be followed both in the school shop and in industry.

There are several ways of helping to secure your place in this fast-paced field. These methods can assist you in staying current with the most recent changes in technology and help you network with other professionals.

1. Read trade journals, service manuals, textbooks, and trade catalogs.
2. Join associations such as the American Welding Society.
3. Research topics on the Internet.
4. Trade tips with your peers.

ABOUT WELDING

Welding Processes

The welding process using electron beams was first developed in the 1950s by the French Atomic Energy Commission, by J. A. Stohr. During this same time, the Russians were perfecting a method of solid-state joining called friction welding. In the United States, General Motors started using an electroslag welding process.



CHAPTER 1 REVIEW

Multiple Choice

Choose the letter of the correct answer.

- When did humans learn the art of welding? (Obj. 1-1)
 - Early 1990s
 - Around the birth of Christ
 - Between 3000 and 2000 B.C.
 - Welding started between World Wars I and II
- Name four metals that were used by early metalworkers. (Obj. 1-1)
 - Copper, bronze, silver, gold
 - Zinc, pewter, aluminum, lead
 - Silver, mercury, vanadium, gold
 - Cast iron, steel, brass, tin
- Which metal was probably the first to be worked by early metalworkers? (Obj. 1-1)
 - Pewter
 - Gold
 - Copper
 - Tin
- When was fusion welding, as we know it, first developed? (Obj. 1-1)
 - In 1888 by a Russian
 - In 1892 by C. L. Coffin
 - In 1881 by Auguste de Meritens
 - In 1930 by Hobart & Devers
- Electric arc welding using an electrode was developed around what period? (Obj. 1-1)
 - 1880–1900
 - 1930–1942
 - 1750–1765
 - 1950–1965
- In what country was a patent first issued for electric arc welding? (Obj. 1-1)
 - France
 - China
 - Russia
 - United States
- What invention gave the electric arc welding process its greatest boost? (Obj. 1-1)
 - Covered electrodes
 - Oxyacetylene gas mixture
 - Workable electric generating devices
 - Both a and c
- Oxyacetylene welding was developed around what period? (Obj. 1-1)
 - 1720–1740
 - 1890–1900
 - 1930–1942
 - 1950–1965
- Using American Welding Society Standards, name four popular welding processes in use today. (Obj. 1-2)
 - SMAW, GTAW, GMAW, ESW
 - MCAW, CAW, EBW, OHW, LBW, ARTW
 - SSW, ROW, FLB, AAW
 - GLUEW, STKW, GASW, MIGW
- When was a patent issued for the GTAW process? (Obj. 1-2)
 - 1936
 - 1942
 - 1948
 - 1965
- When was a patent issued for the GMAW process? (Obj. 1-2)
 - 1936
 - 1942
 - 1948
 - 1965
- What is welding? (Obj. 1-3)
 - Hammering two pieces of metal together until they become one
 - Using rivets or screws to attach metal
 - Bending and shaping metal
 - Joining together two pieces of metal by heating to a temperature high enough to cause softening or melting, with or without the application of pressure and with or without the use of filler metal
- Welding is _____ and there are many jobs available for both men and women. (Obj. 1-3)
 - Gender friendly
 - Nonskilled
 - Easy learning
 - Filler type
- In electric arc welding, which of the following does the welder *not* have to regulate? (Obj. 1-4)
 - Cruise control
 - Welding current
 - Electrode
 - Shielding gas
- Even with the proper equipment, which of the following would be very difficult to weld? (Obj. 1-4)
 - Aluminum
 - Magnesium

- c. Stainless steel
 - d. All of these
16. Which of the following lists *classifications* of welding occupations? (Obj. 1-5)
 - a. Combination welder, welder fitter, welding inspector, welding instructor, welding engineer
 - b. Junk yard welder, wanna-be welder, art welder, stick welder
 - c. Inside welder, outside welder, underwater welder, upside-down welder
 - d. Flat welder, vertical welder, horizontal welder, overhead welder
 17. Which of the following is *not* a welding occupation? (Obj. 1-5)
 - a. Certified welding inspector
 - b. Pilot technician
 - c. Instructor
 - d. Technical editor
 18. Welders are required to pass periodic qualification tests established by various _____. (Obj. 1-6)
 - a. Code authorities
 - b. Training agencies
 - c. Insurance companies
 - d. Both a and c
 19. If you are a competent welder, you need to know _____ skills. (Obj. 1-7)
 - a. Drawing
 - b. Math
 - c. Layout skills
 - d. All of these
 20. Job hazards can be minimized or eliminated by the use of _____. (Obj. 1-8)
 - a. Protective clothing
 - b. Face shields
 - c. Adequate ventilation
 - d. All of these
 21. Which of the following is *not* a trade association related to the welding industry? (Obj. 1-9)
 - a. AWS
 - b. ASME
 - c. AUPS
 - d. API
 22. Establishing goals such as _____ will help secure your achievement as a skilled welder. (Obj. 1-10)
 - a. Join a professional organization
 - b. Nonstop classroom work
 - c. Friendly equipment
 - d. Trade vocation

Review Questions

Write the answers in your own words.

23. Is welding a recent industrial process? Explain. (Obj. 1-1)
24. Name four metals that were used by early metalworkers. Which metal was the first to be worked? (Obj. 1-1)
25. When did the manufacture of steel begin? (Obj. 1-1)
26. In what country was the patent for electric arc welding first issued? (Obj. 1-2)
27. What invention gave electric arc welding its greatest boost? (Obj. 1-2)
28. Name four important welding processes. (Obj. 1-4)
29. Is it true that industry uses MIG/MAG welding only for special applications because of its instability? Explain. (Obj. 1-4)
30. Name 10 occupational classifications in the welding industry. (Obj. 1-5)
31. Name three welding occupations that require a college degree. (Obj. 1-5)
32. Which welding process contributed most to aluminum welding? (Obj. 1-10)

INTERNET ACTIVITIES

Internet Activity A

Search on the Web for books about welding at England's Cambridge International Science Publishing. Make a list of books that sounds interesting to you.

Internet Activity B

Using the Internet, search for safety and health guidelines for welding and write a report on your findings. You may want to try the American Welding Society's Web site: www.aws.org.