

# Check out the Stainless Steel Pipe Welding

Stainless steel pipe welding is gravy work. Always has been. Always will probably be.

When you can do it and get it done well, you are the man and you may never starve yourself. But it takes some care about detail to do it right.

The most important thing that separates the men in the boys or do i need to say, the genuine welders from the rod burners is the willingness to follow along with procedures for welding stainless steel. Procedures like expecting the pipe for cooling among passes, keeping the hot tip in the rod shielded with argon, snipping the end of the tig welding rod in the event it gets crapped up, keeping your tungsten sharp.

One of the primary procedures After all is PURGE. Stainless absolutely needs to be purged with argon gas in order to prevent sugaring. Sugaring is also called granulation but it's severe oxidation regardless of what you call it.

You cant even pull off tack welding lacking an argon purge that shield the trunk side or interior of your pipe. So how do you do it? How do you protect a corner affiliate with argon?

Usually it's done with aluminum duct tape. The ends of your stainless pipe are taped shut as well as the whole inside is purged with argon gas. Even opening from the pipe joint is taped in order that argon can fill your entire pipe and push out any oxygen. The tape is peeled back ample to secure a tack once the pipe is purge enough.

What is enough? Inside your tell without a doubt is with an oxygen analyzer. A bic lighter will not do just fine. Even 2% oxygen content will blow out a bic lighter. And 2% oxygen will result in a black root pass.

There are a few other smart approaches to check the purge but an oxygen analyzer could be the sure way.

Here are a couple tips that will help get a full purge about the stainless steel pipe you weld.

Make sure there isn't any water inside pipe...not really a drop. A single drop water will throw a monkey wrench in your purging until it evaporates. Remember precisely what is in water? Hydrogen and oxygen. Poke a vent hole inside the uppermost placed you will get. Think about argon as if it had been water. Which is heavier than air, it is going to fill up any space like water, displacing the environment mainly because it fills every nook and cranny.

More purge gas flow isn't necessarily better. A high and turbulent flow of argon is not going to necessarily purge a pipe quicker than a lower flow rate. As well as a diffuser about the end in the end of one's argon hose usually allows you to make use of a higher flow rate. A homemade diffuser can be achieved by incorporating stainless wool , some perforated stainless sheet, as well as a amount of sheet metal.

When you verify a fantastic purge, you are to tack. Peel the tape back just enough to tack and let cool a bit and re tape. Then tack again 180 degrees apart. Continue until all tacks are in place.

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