

### Module Overview

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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

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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

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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

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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

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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.

# 9301 16 Open Root Welds Trainee Guide

**R Barnett**



## **9301 16 Open Root Welds Trainee Guide:**

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