[https://youtu.be/4MKuUICV6-c](https://youtu.be/4MKuUICV6-c%22%20%5Ct%20%22_blank) **Stick Welding 101**

1. The grounding lead for an ARC Welder is connected to the \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ terminal.

 Answer: Negative terminal

2. The electrode holder for an Arc Welder is connected to the \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ terminal.

 Answer: Positive terminal

Define:

3. DCEP

 Answer: Direct Current Electrode Positive

 DCEN

 Answer: Direct Current Electrode Negative

4. On an E6010 Electrode, the number 60 stands for tensile strength. What does tensile strength mean?

 Answer: Amount of tension (being pulled apart) the material can resist before failing.

5. The third number (1) stands for position. What does the #1 indicated on a 6010 electrode according to the video?

Answer: All Positions

 What positions does the # 2 indicate?

 Answer: Flat and Horizontal

6. The last number (0) stands for flux composition and also polarity. According to the video, what will flux composition determine?

 Answer: How the weld puddle reacts with the metal

7. Why don’t you want to push or use extreme angles when welding with and electrode?

 Answer: You want to direct the arc down into the material

8. What degree angle would you use to drag the electrode? A.) 90 degrees

B.)10-15 degrees

C.) 20-30 degrees

D.) 45degrees

 Answer: B.) 10-15 degrees

9. What amperage range is good for using an E6010 electrode on DC current?

 Answer: 85 Amps

10. After your run the 6010 bead on the metal and if you used the correct technique and amperage, your bead should be \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_. Answer: twice the size of your rod

11. What is the main difference between a 6010 and a 6011 electrode?

 Answer: A 6011 can be run with AC (Alternating Current)

 True or False: the electrode doesn’t penetrate or dig quite as much on AC.

 Answer: True

12. What is the amperage the instructor used on the 6011 electrode in the DCEP position?

 Answer: 70 Amps

13. What is the stitch or “whip” technique?

Answer: A violet motion of the electrode holder when welding. You step completely out, freeze,

and come back on the leading edge of the weld.

14. Why is a 6011 electrode a good farm rod?

 Answer: A good rod to use for repairing metal equipment because it eats through rust and mill

 scale.

15. What are the three polarities a 6013 electrode will weld in?

 Answer: DCEP, DCEN, and AC

16. On this video, he ran the 6013 on DCEP using \_\_\_\_\_\_\_\_\_\_\_\_\_\_amps.

 Answer: 100 Amps

17. When he used Alternating Current (AC) with the 6013, what was his Amperage?

 Answer: 115 Amps

18. On the 7018, unlike the 6010, this rod will weld only in the \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_.

 Answer: Vertical position uphill

19. Why do you not want to run the 7018 rod going downhill?

 Answer: Slag is too fluid. It will run right down into your weld pool.

20. What size 7018 rod was the instructor using on AC in the video?

 Answer: 3/32”

 What was his amperage?

 Answer: 85 Amps