

TO STUDY THE MECHANICAL PARAMETER OF SUB MERGED ARC WELDING PROCESS

¹Manoj Kumar, ²Kuldeep Boora, ³Lalit, ⁴Somvir Arya

Introduction

SAW is one of the non pressure electric arc welding process. It requires a continuously fed consumable solid electrode. The weld and the arc zone are protected from atmospheric contamination by being “Submerged” under a blanket of granular fusible flux. When molten, the flux becomes conductive and provides a current path between the electrode and the work. The thick layer of flux completely covers the molten metal thus preventing spatter and sparks as well as suppressing the intense ultraviolet radiation and fumes. SAW is normally operated in the automatic or mechanized mode, however, semi-automatic SAW guns with pressurized or gravity flux feed delivery are available.



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Principle Of Operation

The modern SAW is an arc welding process, in which one or more arcs formed between one or more bare wire electrodes and the work piece provides the heat for coalescence. The flux is supplied through a funnel located ahead of the filler wire which is fed continuously.

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