

Deposited Metal

Fillet Weld Size		Volume		Weight	
in.	mm	in. <sup>3</sup> /ft	mm <sup>3</sup> /mm	lb/ft	kg/m
3/16	5	0.34	18.2	0.10	0.15
1/4	6	0.43	21.1	0.12	0.18
5/16	8	0.68	36.6	0.19	0.28
3/8	10	0.96	51.2	0.27	0.40
7/16	11	1.3	69.9	0.36	0.54
1/2	13	1.7	91.4	0.48	0.71
5/8	16	2.5	13.4	0.71	1.06
3/4	19	3.6	19.4	1.0	1.5
7/8	22	5.0	26.9	1.4	2.1
1	25	6.4	34.4	1.8	2.9



## Deposition Efficiency for Welding Processes and Filler Metals

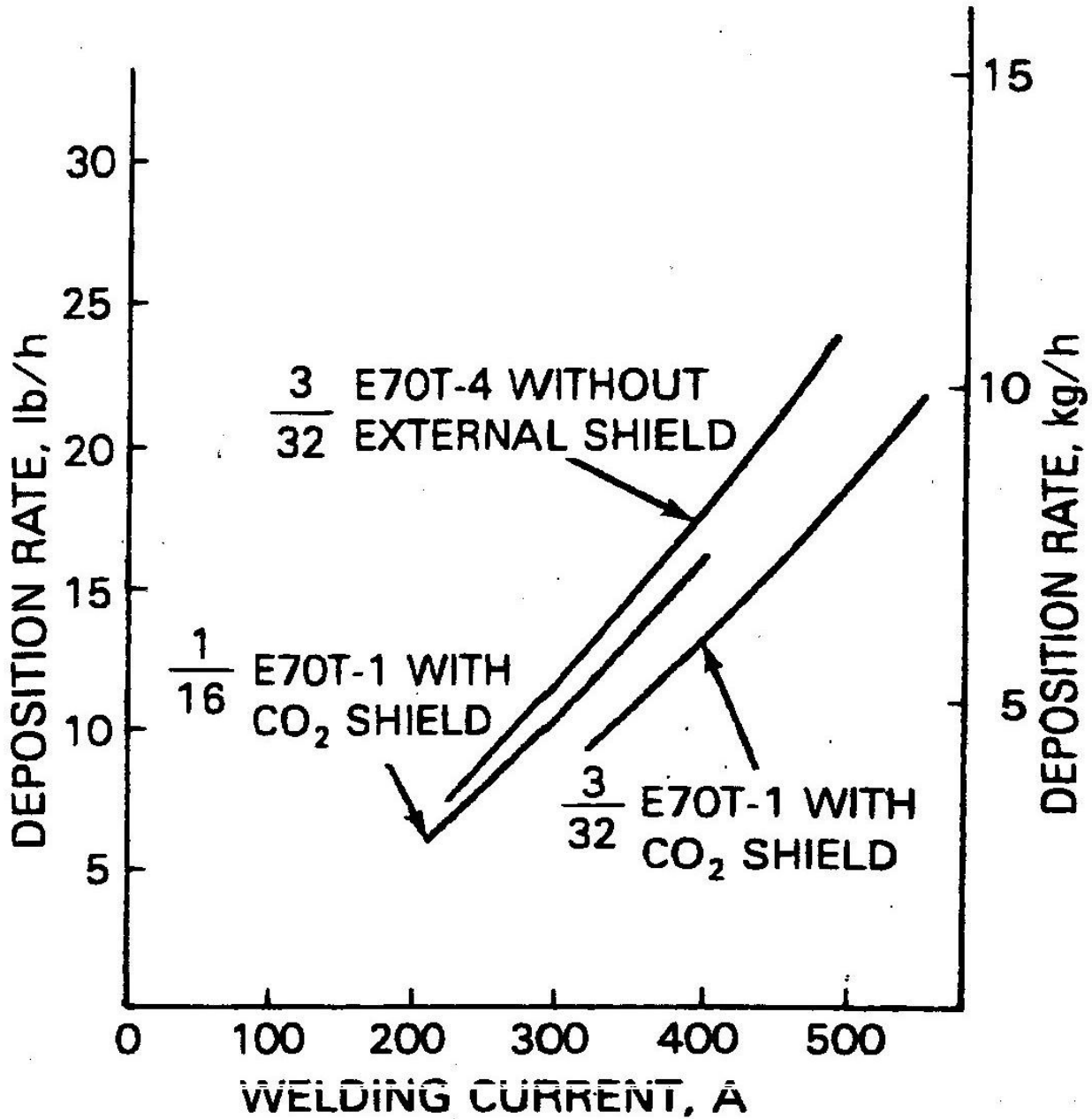
Filler Metal Form and Process	Deposition Efficiency, % <sup>a</sup>
Covered electrodes (SMAW)	
14 in. long	55 to 65
18 in. long	60 to 70
28 in. long	65 to 75
Bare solid wire	
Submerged arc welding (SAW)	95 to 99
Gas metal arc welding (GMAW)	90 to 97
Flux cored electrodes (FCAW)	80 to 90

a. Includes stub loss.

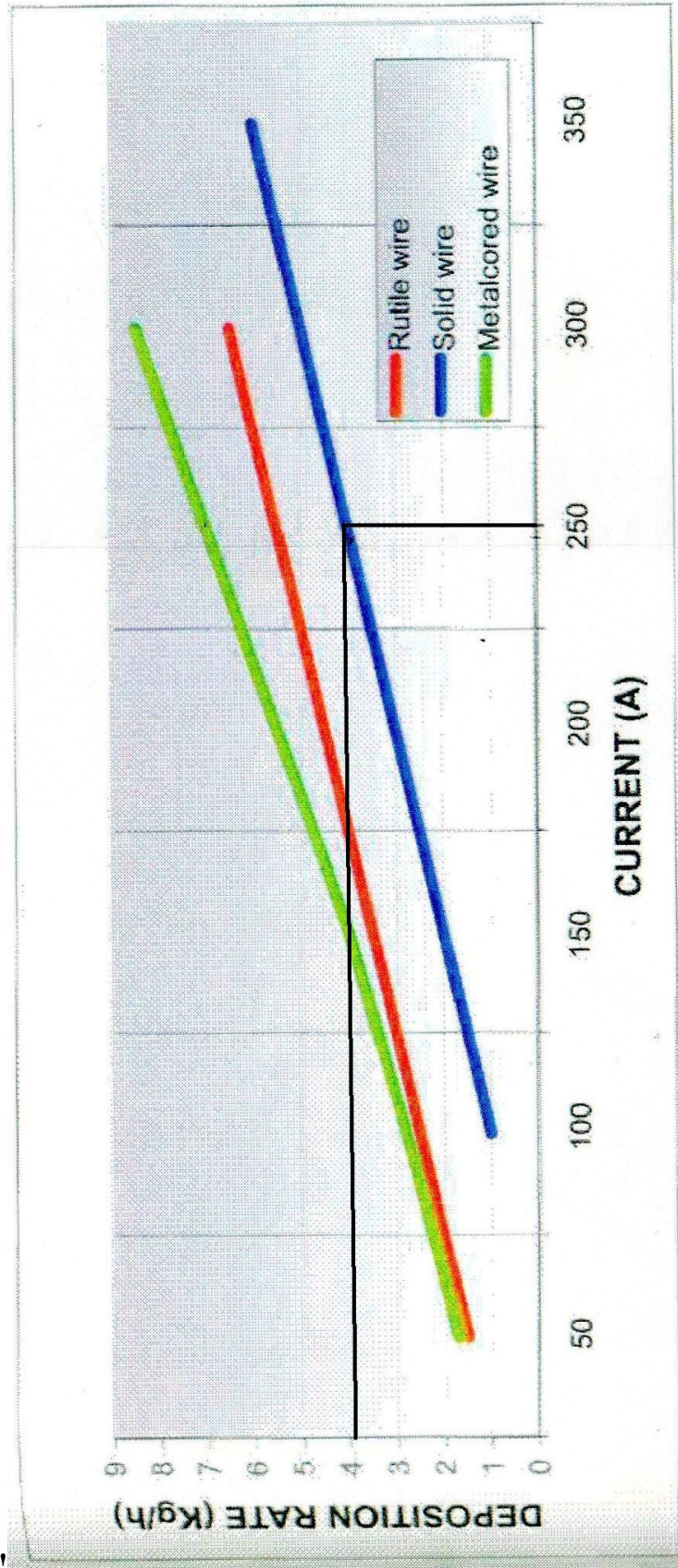


## **Operator Factor for Various Welding Methods**

<b>Method of Welding</b>	<b>Operator Factor Range, Percent</b>
<b>Manual</b>	<b>50-30</b>
<b>Semiautomatic</b>	<b>10-60</b>
<b>Machine</b>	<b>40-90</b>
<b>Automatic</b>	<b>50-100</b>



NOTE: Deposition rate will vary with electrode extension.



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