

ABSTRACT

WELDING PROCESS

The invention provides a method of arc welding, characterised by holding the arc current at a reduced level at the start of the welding operation thereby to avoid substantial welding of the work until at least a major proportion of the particles displaced by the plasma flow at the generation of the arc have dissipated, and thereafter increasing said arc current to the regular level for welding; thereby to reduce contamination of the work by the particles. The work may be a joint between two pipes; a back shielding gas may be applied in the pipes.

(Please note that Figure 1 should accompany the abstract when published)