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Osha - 30 Post a comment Name: Email: Your Email: Comments: Yes, I would like to receive e-mails from SAMPLES!Q: Substantial movement of plate after heavy plate setup I have been troubleshooting a plate which has gone out of alignment after one of the welds. One of the plates is much thicker than the other, and the problem is that the heavier one has moved about a quarter of an inch. The setup for this plate was to weld it to two old 75mm by 8mm plates using MIG on a MIG welding machine, then get a little bit of weld underneath the plate using a MIG welding machine and tig, then a few more MIGs, then tig, then repeat the same until I had a decent-looking plate. The setup for the lighter plate is tig and MIG. The problem with the lighter plate is that it has moved too far after only 1-2 MIGs. Is there anything I can do to fix this, or is it time to send this in? A: You need to establish the cause of the movement by taking a series of photos so that you can post them for reference. If this is your first plate, you'll need to establish the characteristics that allow for this kind of movement and establish procedures for ensuring that the movement is not repeated. There are many causes of movement. You welded the plate and it cracked, and the fractured material allowed the plate to move. As @Robert points out, this could have been prevented by observing the plate carefully, preferably from as many angles as possible. As @Chris says, the thermal expansion coefficient of the different plates could cause this. You have used filler rod with very high material (0.5% Si) and are now trying to weld only with argon gas. I assume that your gas source is a solid gun. The tungsten is not conductive enough to provide the required electrical current for the welding. Argon is not as good a conductor of heat and heat flux as welding gas mixtures, so the heat input to the plate is less, less heat is transmitted to the weld, and less metal is melted, and thus the weld is weaker. In addition, the gas will be less effective at filling in spaces between the welds. Your plating thicknesses (16mil vs

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