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A Practical Manual of Oxy-Acetylene Welding and Cutting, with a Treatise on Acetylene and Oxygen

By Prior F Willis

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 .perpendicular to the work. In welding the torch should not be directed upon a particular spot for any great length of time, but should move slightly so that the flame will come in contact with other parts in the immediate vicinity. This should not be understood to mean that the torch should sweep a circle whose diameter is one or two inches. Most beginners make this mistake. The torch should be moved not more than 1/4. or 5/16 of an inch at a time for average work--say or 1/2 in thickness. A circular motion for metal of this thickness is not essential, but it is well to acquire it. For sheet metal work this circular movement is very desirable, producing a very smooth and pretty weld. However, there are some that prefer an oscillatory movement, the torch being pushed like a pendulum from one side...



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