**Butt Weld Technique (Walking the Cup)**

**Open Root Geometries**

PASS 1
**OPEN ROOT** (.035 Wire)
125 to 145 amps - 25 to 35 WFS
**CLOSED ROOT** (.035 Wire)
170 to 200 amps - 20 to 30 WFS

The heavier the wall the greater the amperage as it acts as a heat sync.

Amperage also depends on the operator and his WFS and travel speed.

When rooting the pipe, you must stay on the leading edge of the puddle and maintain this throughout the process.

PASS 2 FILL
200 to 250 amps - 45 to 60 WFS

PASS 3 or PASS 3 - 4 CAP
170 to 200 amps - 30 - 40 WFS

**Closed Root Geometries**

2G Fixed, 5G Fixed, 6G Incline Fixed use lower settings.

1G Rotating use higher settings.

Sch 40

Sch 80