



Nice bead –  
even crown

Back side –  
barely any  
deformation

Voltage too  
high – bead  
is flat

Back side –  
over  
penetration





No shielding  
gas (argon) –  
weld beads on  
surface –  
can't lay  
down a  
straight line

Voltage too  
low – bead  
is rounded  
and sits on  
the surface

