Travel too fast. Narrow bead, poor wetting at toes.

Travel too slow. Bead too wide, arc too hot.

Voltage too high. Globular transfer, poor arc control.

Voltage too low. Excessive spatter, poor arc control.

No gas. Pinholes and porosity in weld.

Amperage too high. Wide bead, excessive spatter, possible burn-through.

Amperage too low. Narrow, high-crowned bead.

A Good Weld

Proper bead size and height.

What is a Good Weld?

MillerWelds.com