

**Table 1: Weld Sample 1 distortion data (Welded from Right to Left, 160-180 amps, 3/32" tungsten):**

	Left					Center					Right					Com
	Inside	Outside	Shrinkage	Purge Gap	Backside	Inside	Outside	Shrinkage	Purge Gap	Backside	Inside	Outside	Shrinkage	Purge Gap	Backside	
Tack	0.319					0.304					0.330					No V
1st Pass	0.277		-0.042			0.285		-0.019			0.310		-0.020			1/16"
2nd	0.260		-0.017			0.261		-0.024			0.299		-0.011			1/16"
3rd	0.237		-0.023			0.236		-0.025			0.268		-0.031			3/32"
4th	0.225		-0.012			0.223		-0.013			0.257		-0.011			3/32"
5th		1.467					1.472					1.497				3/32"
6th		1.461	-0.006				1.453	-0.019				1.488	-0.009			3/32"
7th		1.457	-0.004				1.450	-0.003				1.478	-0.010			3/32"
8th Final		1.450	-0.007	0.092	1.508		1.440	-0.010	0.101	1.526		1.474	-0.004	0.118	1.563	3/32"
<b>Total shrinkage</b>			<b>-0.111</b>					<b>-0.113</b>					<b>-0.096</b>			
<b>Avg per pass</b>			<b>-0.028</b>					<b>-0.028</b>					<b>-0.024</b>			