

Terms used in occupational qualification standard of Welder

Käsikeevitus	<i>manual welding</i>	Welding performed manually by the welder.
Poolautomaatkeevitus	<i>semiautomatic welding, partly mechanised welding</i>	A partly mechanised welding method (usually manual welding where the feeding of the extra metal in the form of welding wire or tape is automatised and movement along the welding seam is done with manual assistance from the welder).
Automaatkeevitus	<i>automatic welding</i>	Automatised welding which is performed completely by devices where the weld head's movements and position are regulated by the appropriate tools.
Käsikaarkeevitus ehk elektroodkeevitus	<i>MMA welding, or SMAW.</i>	Manual metal arc welding or shielded metal arc welding. Electric arcs (the heat energy from the arc gas) are used as the source of energy in arc welding.
Gaaskeevitus	<i>Gas welding</i>	The necessary heat to melt metal in gas welding comes from a flame lit from a combination of a combustible gas and oxygen. The combustible gas may be acetylene or propane. In most cases, extra metal is used in the form of wire.
MIG-keevitus ehk kaarkeevitus inertgaasi keskkonnas	<i>MIG welding</i>	The number for the welding process that belongs to the group of semi-automatic welding processes is 131 according to the EN ISO 4063 standard. The most common inert gas used in welding is argon (Ar); helium (He) is used less commonly. Aluminium is usually used in welding.
MAG-keevitus ehk kaarkeevitus aktiivgaasi keskkonnas	<i>MAG welding</i>	The number for the welding process that belongs to the group of semi-automatic welding processes according to the EN ISO 4063 standard is 135 for solid-wire welding and 136 or 138 for flux-cored wire welding. Flux-cored wire welding uses a pipe-shaped wire electrode or flux-cored wire, which contains gas-creating substances, deoxidisers, etc. Carbon dioxide is usually used as a shielding gas in flux-cored wire welding. The most commonly used active gas in welding is carbon dioxide, CO ₂ . Often a mix of argon and carbon dioxide is used, such as AGAMIX-20, which is 80% argon and 20% carbon dioxide.

TIG-keevitus	<i>TIG welding, or GTAW</i>	<p>An arc welding process involving a non-consumable electrode where the welding arc is burnt between a non-consumable electrode (usually wolfram) and parts and the arc space is protected using an inert gas directed into it.</p> <p>Formerly known as argon welding. The following subcategories are marked by the following numeric codes.</p> <p>141 – TIG welding with an additional solid material which is conducted into the weld pool as a wire or rod.</p> <p>142 – TIG autogenous welding without an additional material. The edges of the parts are melted together.</p> <p>143 – TIG welding with a flux-cored additional material. The additional material is directed into the weld pool as flux-cored wire or rods.</p> <p>145 – TIG welding in a reducing shielding gas and with a solid additional material (wire or rod)</p>
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