### Porosity
- **Possible Causes**
  - Long Arc Length
  - Dirty Base Metal
  - Inadequate Gas Coverage
- **Possible Cures**
  - Use Proper Arc Length
  - Clean Base Metal
  - Check for Proper Gas Coverage

### Undercut
- **Possible Causes**
  - Improper Leg Size
- **Possible Cures**
  - Use Proper Electrode Angle
  - Use Proper Travel Speed

### Incomplete Fusion
- **Possible Causes**
  - "Cold" Welding Procedures
  - Travel Speed Too Slow
  - Travel Speed Too Fast
- **Possible Cures**
  - Increase Current
  - Use Proper Travel Speed

### Incomplete Joint Penetration
- **Possible Causes**
  - "Cold" Welding Procedures
  - Travel Speed Too Slow
  - Improper Joint Detail
- **Possible Cures**
  - Increase Current
  - Use Proper Travel Speed

### Excessive Reinforcement
- **Possible Causes**
  - Travel Speed Too Slow
  - "Cold" Welding Procedures
- **Possible Cures**
  - Increase Travel Speed
  - Increase Current

### Underfill
- **Possible Causes**
  - Insufficient Weld Metal
- **Possible Cures**
  - Increase Travel Speed

### Concave Root Surface (Suck-back)
- **Possible Causes**
  - Too Much Current
  - Arc Length Too Long
  - Root Face Too Small
- **Possible Cures**
  - Reduce Current
  - Maintain Proper Arc Length
  - Use Proper Joint Fitup

### Non-uniformity
- **Possible Causes**
  - Improper Electrode Angle
- **Possible Cures**
  - Correct Welding Technique

### Improper Leg Size
- **Possible Causes**
  - Improper Electrode Angle
- **Possible Cures**
  - Use Correct Welding Technique

### Overlap
- **Possible Causes**
  - Travel Speed Too Slow
  - "Cold" Welding Procedures
- **Possible Cures**
  - Use Proper Travel Speed

### Arc Strikes
- **Possible Causes**
  - Improper Welding Technique
- **Possible Cures**
  - Initiate Arc Inside the Weld Joint

### Slag Inclusions
- **Possible Causes**
  - Improper Welding Technique
- **Possible Cures**
  - Use Correct Welding Technique
  - Clean Weld Between Passes