



The SESK Party Game

STUFF EVERY WELDER SHOULD KNOW

How to play (30 seconds)

1. The reader reads a card and its three answers out loud.
2. Everyone says "One, two, three, Goldilocks!" and holds up 1, 2, or 3 fingers.
3. The reader flips the card and reads the answer and the Why.
4. Everyone who was right takes a point.
5. The reader reads the joke with a straight face. Anyone laughs or groans? The reader takes a point. Nobody got it right? The reader takes a point.
6. Pass the deck left. Most points when the points run out wins.

What you need

These cards and the point tokens on the last two pages. No tokens? Use coins, buttons, pebbles, or marshmallows. 3 to 10 players, ages 8 and up.

Expert rule: Bet It

Before the reader flips the card, you may put one of your points on your answer. Right: take your normal point plus one extra. Wrong: your bet goes back to the pile. That's it.

Printing

Print single-sided, on cardstock if you have it. Cut on the dashed lines. Each card is a 3.5 x 5 inch index card. The answer half is upside down on purpose, so the table can't peek. Cards 1 to 50 of 100. More cards and the free daily online game at sesk.info. Built 2026-10-12.

TRADES & SHOP



What polarity does MIG welding of mild steel use?

- A** DC electrode positive (reverse polarity)
- B** DC electrode negative (straight polarity)
- C** Alternating current with no polarity

FLIP FOR THE ANSWER

#6101

SESK.INFO

STRAIGHT FACE
Two atoms were walking down the beach. One said, "Hey, I think I lost an electron." The other asked, "Are you sure?" The first said, "Yes, I'm positive."

A **DC electrode positive (reverse polarity)**
WHY MIG welding runs on direct current with the wire on the positive side. That setup is called DCEP, or reverse polarity.

TRADES & SHOP



Self-shielded flux-cored wires like E71T-11 run on which polarity?

- A** DC electrode positive (reverse polarity)
- B** DC electrode negative (straight polarity)
- C** AC only

FLIP FOR THE ANSWER

#6102

SESK.INFO

STRAIGHT FACE
Did you hear about the mathematician who's afraid of negative numbers? He'll stop at nothing to avoid them.

B **DC electrode negative (straight polarity)**
WHY Hobart says T-8 and T-11 self-shielded wires should run on DCEN. Wrong polarity can add spatter. Solid MIG wire is the opposite and uses DCEP.

TRADES & SHOP



What is the most common shielding gas mix for MIG welding mild steel?

- A** 75% carbon dioxide, 25% argon
- B** 100% helium
- C** 75% argon, 25% carbon dioxide

FLIP FOR THE ANSWER

#6103

SESK.INFO

STRAIGHT FACE
Argon walks into a bar. Nothing happens, because it is inert.

C **75% argon, 25% carbon dioxide**
WHY The 75/25 argon and CO2 blend is the all-purpose choice for carbon steel. It runs smooth with little spatter.

TRADES & SHOP



Compared with 75/25 argon and CO2, what does 100% CO2 shielding gas tend to give?

- A** More spatter and a slightly erratic arc
- B** Less spatter and a smoother arc
- C** A perfectly steady arc with no spatter

FLIP FOR THE ANSWER

#6104

SESK.INFO

STRAIGHT FACE
What do solids, liquids and gasses have in common? They all matter.

A **More spatter and a slightly erratic arc**
WHY Pure CO2 is called C-100. Miller says it may produce a bit more spatter and a slightly erratic arc compared with a 75/25 blend.

TRADES & SHOP



What shielding gas is most common for MIG welding aluminum?

- A** 100% carbon dioxide
- B** 100% argon
- C** 75% argon, 25% carbon dioxide

FLIP FOR THE ANSWER

#6105

SESK.INFO

STRAIGHT FACE
Helium walks into a bar. The bartender says, "Helium doesn't react."

B 100% argon
WHY Aluminum is MIG welded with pure argon. The CO2 mixes used on steel are the wrong choice for aluminum.

TRADES & SHOP



Which shielding gas works for all TIG applications, all metals and thicknesses?

- A** Carbon dioxide
- B** Oxygen
- C** Argon

FLIP FOR THE ANSWER

#6106

SESK.INFO

STRAIGHT FACE
Why did the noble gas cry? Because all of his friends argon.

C Argon
WHY Argon is the go-to TIG gas for any metal and any thickness. An argon and helium blend is another option.

TRADES & SHOP



When TIG welding steel, which polarity setting does Miller recommend?

- A** DC electrode negative (DCEN)
- B** DC electrode positive (DCEP)
- C** AC

FLIP FOR THE ANSWER

#6107

SESK.INFO

STRAIGHT FACE
Why did the electron stay home from school? It was feeling a little negative.

A DC electrode negative (DCEN)
WHY Steel and steel alloys are TIG welded on DC with the torch on the negative side. Aluminum switches to AC.

TRADES & SHOP



What current type is used for TIG welding aluminum?

- A** DC electrode negative
- B** AC
- C** DC electrode positive

FLIP FOR THE ANSWER

#6108

SESK.INFO

STRAIGHT FACE
What did one charged atom say to the other? I got my ion you.

B AC
WHY Set the welder for the base metal. Miller says AC for aluminum and DC for steel.

TRADES & SHOP



Which welding wire needs no external shielding gas?

- A** Solid MIG wire
- B** Gas-shielded flux-cored wire
- C** Self-shielded flux-cored wire

FLIP FOR THE ANSWER

#6109

SESK.INFO

STRAIGHT FACE
Why wasn't the stadium hot after the game?
Because there were so many fans.

C Self-shielded flux-cored wire
WHY Self-shielded wire carries flux in its core that makes its own protective gas. No gas bottle is needed.

TRADES & SHOP



Should you push or drag a flux-cored gun?

- A** Drag (pull) it
- B** Push it
- C** Either, it makes no difference

FLIP FOR THE ANSWER

#6110

SESK.INFO

STRAIGHT FACE
What happens when a frog's car breaks down? It gets toad.

A Drag (pull) it
WHY Miller says flux-cored welding should always use a drag technique. Their rule of thumb is simple: if there's slag, you drag.

TRADES & SHOP



A typical MIG stickout is about how long?

- A** About 1 inch
- B** About 3/8 inch
- C** About 1/8 inch

FLIP FOR THE ANSWER

#6111

SESK.INFO

STRAIGHT FACE
Stickout is the one thing a welder wants short and sweet, like a good dad joke.

B About 3/8 inch
WHY Stickout is the unmelted wire sticking out of the contact tip. Around 3/8 inch is typical for MIG. Longer stickout reduces heat input.

TRADES & SHOP



On a MIG welder, wire feed speed mainly affects which two things?

- A** Gas flow and slag removal
- B** Wire color and tip life
- C** Amperage and weld penetration

FLIP FOR THE ANSWER

#6112

SESK.INFO

STRAIGHT FACE
Knock, knock. Who's there? Wire. Wire who? Wire you always asking, "Who's there?"

C Amperage and weld penetration
WHY Faster wire feed means more amps and more penetration. Too much can cause burn-through.

TRADES & SHOP



Miller's rule: about how many amps for 1/8 inch steel with MIG?

- A** About 125 amps
- B** About 60 amps
- C** About 250 amps

FLIP FOR THE ANSWER

#6113

SESK.INFO

STRAIGHT FACE
Who was the first electricity detective? Sherlock
Ohms.

A About 125 amps
WHY Miller says each .001 inch of thickness needs about 1 amp. A 1/8 inch (.125) plate is 125 thousandths, so about 125 amps.

TRADES & SHOP



In the stick electrode E7018, what does the 70 mean?

- A** A recommended 70 amps
- B** 70,000 psi minimum tensile strength
- C** A 70 percent flux coating

FLIP FOR THE ANSWER

#6114

SESK.INFO

STRAIGHT FACE
E7018 is a high achiever. Its strength is a solid 70 out of 70.

B 70,000 psi minimum tensile strength
WHY The first two digits of an AWS stick electrode code show tensile strength in thousands of psi. E7018 makes weld metal at least 70,000 psi.

TRADES & SHOP



In an AWS stick electrode code like E7018, the third digit tells you what?

- A** The type of flux color
- B** The diameter of the rod
- C** The welding positions it can be used in

FLIP FOR THE ANSWER

#6115

SESK.INFO

STRAIGHT FACE
You know what seems odd to me? Numbers that can't be divided by two.

C The welding positions it can be used in
WHY The first two digits give strength. The third gives positions, and a 1 means all positions. The fourth gives coating and current type.

TRADES & SHOP



Miller says to store opened low hydrogen E7018 electrodes at what temperature?

- A** 250 to 300 degrees F
- B** About 70 degrees F
- C** Below freezing

FLIP FOR THE ANSWER

#6116

SESK.INFO

STRAIGHT FACE
There are two muffins baking in the oven. One muffin says to the other, "Phew, is it getting hot in here or is it just me?" The other muffin says, "AAAAHHH!! A TALKING MUFFIN!"

A 250 to 300 degrees F
WHY Low hydrogen rods soak up moisture, and hydrogen can crack welds. Keeping them warm keeps them dry.

TRADES & SHOP



Which stick electrode digs through rust, oil and paint but runs only on DC?

- A** E7018
- B** E6010
- C** E6013

FLIP FOR THE ANSWER

#6117

SESK.INFO

STRAIGHT FACE
What did the electrician do to his misbehaving son?
He grounded him.

B E6010
WHY E6010 has deep penetration and a tight arc. Miller says it can only be used with DC power sources and is popular for root passes on pipe.

TRADES & SHOP



What can E6011 do that E6010 cannot?

- A** Give low hydrogen welds
- B** Use an iron powder coating
- C** Run on an AC power source

FLIP FOR THE ANSWER

#6118

SESK.INFO

STRAIGHT FACE
Knock, knock. Who's there? Alec. Alec who? Alec-
tricity. Didn't mean to shock you!

C Run on an AC power source
WHY E6010 is DC only. E6011 has a similar deep digging arc but also works on AC, so it suits simple AC buzz box welders.

TRADES & SHOP



Miller says E6013 electrodes should only be used on what?

- A** Clean, new sheet metal
- B** Rusty pipe roots
- C** Thick structural beams

FLIP FOR THE ANSWER

#6119

SESK.INFO

STRAIGHT FACE
E6013 is a clean freak. It will not go near rust, oil or
paint.

A Clean, new sheet metal
WHY E6013 gives a soft arc, minimal spatter and moderate penetration. It does not dig through rust or oil, so the metal must be clean.

TRADES & SHOP



Which stick electrode has a lot of iron powder to boost deposition rates?

- A** E6010
- B** E7024
- C** E6011

FLIP FOR THE ANSWER

#6120

SESK.INFO

STRAIGHT FACE
Why are elephants wrinkly? Because you can't iron
them.

B E7024
WHY E7024 is loaded with iron powder, so it lays down metal fast. It is used for flat and horizontal fillet welds on thicker plate.

TRADES & SHOP



Stick electrodes with AWS codes ending in which digits are low hydrogen?

- A** 10, 11 or 12
- B** 13, 14 or 24
- C** 15, 16 or 18

FLIP FOR THE ANSWER

#6121

SESK.INFO

STRAIGHT FACE
What do the other elements say about hydrogen?
He's such a loner!

C 15, 16 or 18
WHY Rods like E7015, E7016 and E7018 have excellent low hydrogen properties. That helps prevent weld cracking on thick material.

TRADES & SHOP



TIG welding's official name, GTAW, stands for what?

- A** Gas tungsten arc welding
- B** Gas titanium arc welding
- C** Gas thermal arc welding

FLIP FOR THE ANSWER

#6122

SESK.INFO

STRAIGHT FACE
I told a chemistry joke. There was no reaction.

A Gas tungsten arc welding
WHY The arc comes from a tungsten electrode that does not melt. An inert gas, usually argon, protects the puddle.

TRADES & SHOP



A ground tungsten point should be how long compared with its diameter?

- A** About the same as its diameter
- B** About 2.5 times its diameter
- C** About 10 times its diameter

FLIP FOR THE ANSWER

#6123

SESK.INFO

STRAIGHT FACE
What did the triangle say to the circle? "You're pointless."

B About 2.5 times its diameter
WHY A sharpened tungsten gives a focused arc. Miller says to grind it with a fine wheel used only for tungsten, so it stays uncontaminated.

TRADES & SHOP



Miller says to allow how much post-flow gas time after the TIG arc stops?

- A** About 1 second per 100 amps
- B** None, shut gas off with the arc
- C** About 1 second per 10 amps

FLIP FOR THE ANSWER

#6124

SESK.INFO

STRAIGHT FACE
Post-flow is the pause that refreshes. It also cools off the hot tungsten.

C About 1 second per 10 amps
WHY Post-flow keeps argon around the hot tungsten and cooling weld so they do not oxidize. At 100 amps that is about 10 seconds.

TRADES & SHOP



Miller suggests holding the TIG torch at about what angle?

- A** 70 to 80 degrees
- B** 20 to 30 degrees
- C** 45 degrees exactly

FLIP FOR THE ANSWER

#6125

SESK.INFO

STRAIGHT FACE
What is the best way to pass a geometry test?
Know all the angles.

A 70 to 80 degrees
WHY A steep torch angle keeps the arc focused on the puddle. The tungsten should stay no more than 1/16 to 1/8 inch off the workpiece.

TRADES & SHOP



Which joint design is the most common in all applications, per Miller?

- A** Edge joint
- B** T-joint
- C** Lap joint

FLIP FOR THE ANSWER

#6126

SESK.INFO

STRAIGHT FACE
Why did the 30-60-90 triangle marry the 45-45-90 triangle? They were right for each other.

B T-joint
WHY A T-joint is formed when two pieces meet at about 90 degrees, with one edge welded to the flat face of the other.

TRADES & SHOP



In a butt joint, how do the two pieces meet?

- A** One piece overlaps the other
- B** They meet at 90 degrees in an L
- C** Edges meet in the same plane

FLIP FOR THE ANSWER

#6127

SESK.INFO

STRAIGHT FACE
Why did carbon and hydrogen become fast friends? They really bonded.

C Edges meet in the same plane
WHY A butt joint joins two pieces that sit flat in one plane. Edges can be square, beveled, gapped or backed.

TRADES & SHOP



What defines a lap joint?

- A** The surfaces of the two pieces overlap
- B** The edges meet in one plane
- C** The pieces meet at 90 degrees as a T

FLIP FOR THE ANSWER

#6128

SESK.INFO

STRAIGHT FACE
What do you call birds who stick together? Velcrows.

A The surfaces of the two pieces overlap
WHY A lap joint is two overlapping pieces welded where they meet. Thicker material needs more overlap.

TRADES & SHOP



Two pieces joined at 90 degrees to form an L make which joint?

- A** Lap joint
- B** Corner joint
- C** Edge joint

FLIP FOR THE ANSWER

#6129

SESK.INFO

STRAIGHT FACE
How do you keep warm in a cold room? You go to the corner. It's always 90 degrees!

B Corner joint
WHY Pieces joined at 90 degrees in an L shape make a corner joint. In a closed corner the edges sit flush; an open corner leaves a gap showing each edge.

TRADES & SHOP



Why is the flat welding position generally the easiest?

- A** The metal cools much faster
- B** It needs no shielding gas
- C** You are not fighting gravity

FLIP FOR THE ANSWER

#6130

SESK.INFO

STRAIGHT FACE
What do you get when you drop a piano down a mine shaft? A flat minor.

C You are not fighting gravity
WHY In flat welding the molten puddle sits level and stays put. In other positions gravity pulls the puddle around.

TRADES & SHOP



What does the weld puddle naturally tend to do when welding vertically?

- A** Sag
- B** Harden instantly
- C** Float upward

FLIP FOR THE ANSWER

#6131

SESK.INFO

STRAIGHT FACE
Gravity really keeps me grounded.

A Sag
WHY Gravity pulls the molten puddle downward. Welders adjust settings and technique to control it.

TRADES & SHOP



Why is overhead welding often necessary?

- A** It gives the deepest penetration
- B** The work is fixed or immovable
- C** Codes require it on all thin sheet

FLIP FOR THE ANSWER

#6132

SESK.INFO

STRAIGHT FACE
That's a pretty good ceiling. It's not the best, but it's up there!

B The work is fixed or immovable
WHY Welders cannot always rotate the part. When equipment is fixed in place, the weld has to be made from underneath.

TRADES & SHOP



On a weld symbol, what is the arrow side?

- A** The side where the tail is
- B** The side farthest from the arrow
- C** The side of the joint the arrow points to

FLIP FOR THE ANSWER

#6133

SESK.INFO

STRAIGHT FACE
Weld symbols point you the right way. Usually.

C **Why** The side of the joint the arrow points to is the arrow side, and the opposite side is the other side.

TRADES & SHOP



An open circle where the arrow meets the reference line means what?

- A** Weld all the way around the joint
- B** Weld in the field
- C** Grind the weld flush

FLIP FOR THE ANSWER

#6134

SESK.INFO

STRAIGHT FACE
Did you hear about the overeducated circle? It has 360 degrees!

A **Why** An open circle where the arrow meets the reference line means the weld goes all the way around the joint, not just one side.

TRADES & SHOP



A flag at the arrow and reference line junction means the weld is made where?

- A** In the shop
- B** In the field, on site
- C** Underwater

FLIP FOR THE ANSWER

#6135

SESK.INFO

STRAIGHT FACE
What's the best part about living in Switzerland? I don't know, but the flag is a big plus.

B **Why** The field weld flag means the welding happens on site during erection. No flag means it is done in the shop.

TRADES & SHOP



What does a plasma cutter use to cut metal?

- A** A flame of oxygen and acetylene
- B** A beam of ultraviolet light
- C** A jet of ionized gas that conducts electricity

FLIP FOR THE ANSWER

#6136

SESK.INFO

STRAIGHT FACE
Q: Why can't you take electricity to social outings?
A: Because it doesn't know how to conduct itself.

C **Why** Plasma is gas so energized it conducts electricity. A plasma cutter uses that hot jet to melt and blow through metal.

TRADES & SHOP



Oxy-fuel cutting is mainly used on which kind of metal?

- A** Ferrous metals, like carbon steel
- B** Aluminum
- C** Copper and brass

FLIP FOR THE ANSWER

#6137

SESK.INFO

STRAIGHT FACE
I don't lightly interfere; I heavy metal.

A Ferrous metals, like carbon steel
WHY The oxygen jet reacts with the iron in carbon steel to cut it. Miller says oxy-fuel is generally not used on cast iron, aluminum or stainless steel.

TRADES & SHOP



What gas does a typical plasma cutter run on?

- A** Pure acetylene
- B** Compressed air
- C** Pure hydrogen

FLIP FOR THE ANSWER

#6138

SESK.INFO

STRAIGHT FACE
Why did the iron sneak out early on Friday? It ran out of steam.

B Compressed air
WHY Most hand plasma cutters need an electrical supply plus compressed air, which gets turned into plasma.

TRADES & SHOP



For steel thicker than 1 inch, which cutting tool is capable of greater speeds?

- A** A plasma cutter
- B** Neither, thick steel cannot be cut
- C** An oxy-fuel torch

FLIP FOR THE ANSWER

#6139

SESK.INFO

STRAIGHT FACE
I can cut a piece of wood in half just by looking at it. You might not believe me, but I saw it with my own eyes.

C An oxy-fuel torch
WHY Plasma is fast on thinner metal. Past about 1 inch of steel, oxy-fuel can cut faster.

TRADES & SHOP



Which of these is one of the four basic fuel gases used with oxygen for cutting?

- A** Propylene
- B** Argon
- C** Nitrogen

FLIP FOR THE ANSWER

#6140

SESK.INFO

STRAIGHT FACE
What did the Human Torch enter to log into his computer? His user flame.

A Propylene
WHY Oxy-fuel cutters use oxygen with a fuel gas. The four basics are acetylene, propane, propylene and natural gas.

TRADES & SHOP



OSHA says an acetylene cylinder valve must not be opened more than how far?

- A** Three full turns
- B** One and one half turns
- C** All the way until it stops

FLIP FOR THE ANSWER

#6141

SESK.INFO

STRAIGHT FACE
Open the acetylene valve slowly. It hates being rushed, just like dad at a buffet.

B One and one half turns
WHY Opening the acetylene valve only a little keeps it easy to shut off fast in an emergency. OSHA prefers no more than three-quarters of a turn.

TRADES & SHOP



Which flux-cored type needs external gas and has easy-to-remove slag?

- A** Self-shielded flux-cored wire
- B** Solid MIG wire
- C** Gas-shielded flux-cored wire

FLIP FOR THE ANSWER

#6142

SESK.INFO

STRAIGHT FACE
I sold my vacuum the other day. All it was doing was collecting dust.

C Gas-shielded flux-cored wire
WHY Gas-shielded flux-cored wire uses a gas bottle, and its slag comes off easily. Miller suggests it for thicker metals or out-of-position work.

TRADES & SHOP



Which wire is ideal for welding outdoors in windy conditions?

- A** Self-shielded flux-cored wire
- B** Solid MIG wire with argon
- C** Gas-shielded flux-cored wire

FLIP FOR THE ANSWER

#6143

SESK.INFO

STRAIGHT FACE
Two windmills are standing on a wind farm. One asks, "What's your favorite type of music?" The other says, "I'm a big metal fan."

A Self-shielded flux-cored wire
WHY Wind can blow away shielding gas, causing porosity. Self-shielded wire makes its own protection, so it holds up outdoors.

TRADES & SHOP



ER70S-6 solid MIG wire is the usual pick for welding what?

- A** Aluminum
- B** Dirty or rusty mild steel
- C** Stainless steel

FLIP FOR THE ANSWER

#6144

SESK.INFO

STRAIGHT FACE
Where did the chemist put his dirty dishes? In the zinc.

B Dirty or rusty mild steel
WHY ER70S-6 has more deoxidizers than ER70S-3, which helps with surface contamination. ER70S-3 is the all-purpose wire.

TRADES & SHOP



Which argon and CO2 mix does Miller say works well for MIG welding stainless steel?

- A** 75% argon, 25% carbon dioxide
- B** 100% carbon dioxide
- C** 98% argon, 2% carbon dioxide

FLIP FOR THE ANSWER

#6145

SESK.INFO

STRAIGHT FACE
Stainless MIG wire loves 98/2. It is the cleanest relationship in the shop.

C 98% argon, 2% carbon dioxide
WHY Stainless needs low CO2, under 5 percent, to keep extra carbon out of the weld. Miller lists 98% argon, 2% CO2 as a good option.

TRADES & SHOP



What feeder setup does Miller recommend for MIG welding soft aluminum wire?

- A** A spool gun or push-pull feeder
- B** A longer standard liner
- C** Extra stickout

FLIP FOR THE ANSWER

#6146

SESK.INFO

STRAIGHT FACE
Why are metals so calm? They don't easily get alloyed.

A A spool gun or push-pull feeder
WHY Soft aluminum wire is like pushing a wet noodle. A spool gun or push-pull system feeds it a long distance without buckling.

TRADES & SHOP



Hobart suggests what drag angle for E71T-11 self-shielded wire?

- A** 45 to 60 degrees
- B** 10 to 20 degrees
- C** 0 degrees, straight down

FLIP FOR THE ANSWER

#6147

SESK.INFO

STRAIGHT FACE
Why is the obtuse angle always upset? Because it is never right.

B 10 to 20 degrees
WHY T-11 wires should be dragged with a slight angle. Hobart also says they run with a 1/2 to 3/4 inch stickout.

TRADES & SHOP



What does the -1 in an electrode code like 7018-1 mean?

- A** It is for one pass only
- B** It is a first-generation rod
- C** It meets improved toughness requirements

FLIP FOR THE ANSWER

#6148

SESK.INFO

STRAIGHT FACE
What's another name for Silver Surfer and Iron Man? Instant alloys.

C It meets improved toughness requirements
WHY Optional designators add detail to the main code. The -1 on a stick electrode marks improved toughness.

TRADES & SHOP



What gun angle does Miller suggest for a MIG fillet weld?

- A** 45 degrees
- B** 90 degrees
- C** 10 degrees

FLIP FOR THE ANSWER

#6149

SESK.INFO

STRAIGHT FACE
Why did the obtuse angle go to the beach? Because it was over 90 degrees.

A 45 degrees
WHY A fillet weld sits in the corner of two pieces, so aim at the middle of that corner at 45 degrees. A butt joint uses 90 degrees to the work.

TRADES & SHOP



Under OSHA's general industry rule, how long must a fire watch continue after welding or cutting stops?

- A** 5 minutes
- B** At least 30 minutes
- C** 3 hours

FLIP FOR THE ANSWER

#6150

SESK.INFO

STRAIGHT FACE
I bought a friend a fire extinguisher. He was de-lighted.

B At least 30 minutes
WHY Sparks and hot slag can smolder out of sight and start a fire later. OSHA requires a fire watch for at least a half hour after welding or cutting ends.

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