



Shielded Metal Arc Welding (Vertical Welding)

Project 2 – Specification and Print

Weld Type	2 Fillet welds and 1 Square Groove
Welding Process	SMAW
Position	Vertical
Material	¼" Steel
Joint Type	Tee, Lap, and Butt
Backing Option	
Backing Material	

Polarity	DC+
Electrode	E7018 3/32
Transfer Mode	
Tungsten Electrode	
Shielding Gas	
Flow Rate	
Cup Size	

Welding Procedure									
Weld Layers	Pass No.	Process	Filler Metal Classification	Filler Metal Diameter in (mm)	Current Amps	Current Type and Polarity	Wire Feed Speed	Volts	Remarks
Tee	Stringer	SMAW	E7018	3/32	70a	DC+			
Lap	Stringer	SMAW	E7018	3/32	70a	"			
Butt	Stringer	SMAW	E7018	3/32	70a	"			





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Technique: Weld the joints using a vertical up stringer method.

Number of Electrodes: whatever it takes

Heat Treatment:

Preheat Temperature:

Post Heat Temperature:

Interpass Temperature: Quench after each pass

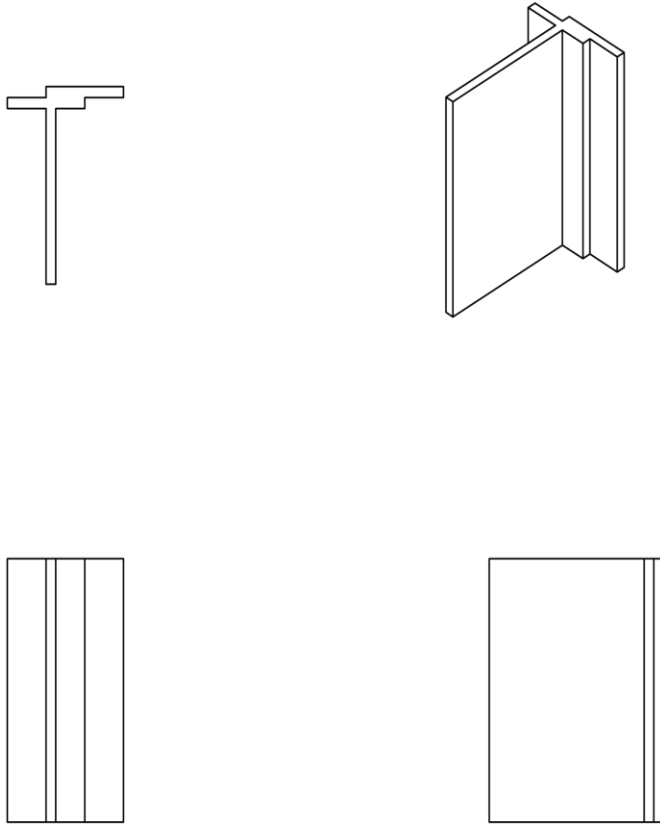
Stress Relieving:

Additional Notes: Show the instructor progress every 30 minute minimum





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		UNLESS OTHERWISE SPECIFIED:		NAME	DATE		
		DIMENSIONS ARE IN INCHES		DRAWN		TITLE:	
		TOLERANCES:		CHECKED		CIMWD-111 Project 2	
		FRACTIONAL ±		ENG APPR.		SIZE DWG. NO. REV	
		ANGULAR: MACH ± BEND ±		MFG APPR.		A PART 16	
		TWO PLACE DECIMAL ±		Q.A.		SCALE: 1:4 WEIGHT: SHEET 1 OF 1	
		THREE PLACE DECIMAL ±		COMMENTS:			
		INTERPRET GEOMETRIC TOLERANCING PER:					
		MATERIAL					
		FINISH					
		APPLICATION					
		DO NOT SCALE DRAWING					

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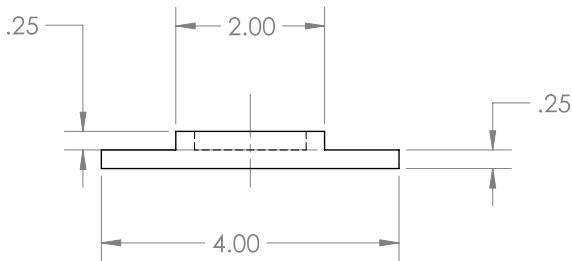
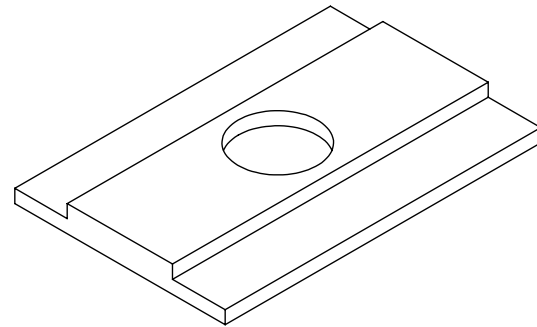
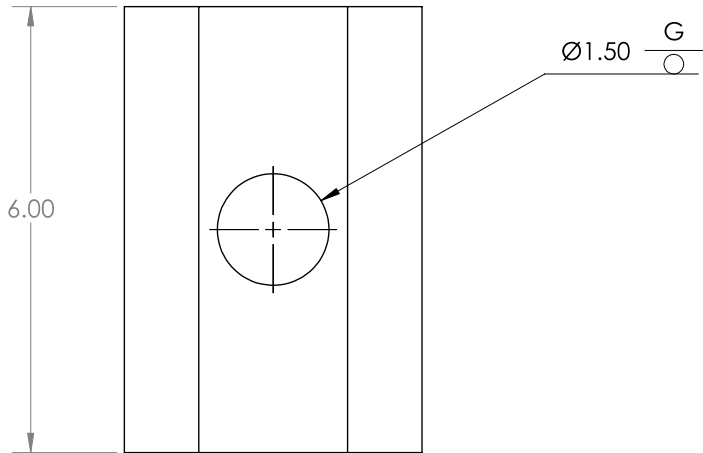
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NOTE: (OFC) PROCESS
TACK WITH GMAW
PLUG WELD SHAW 7018 3/32
CUT IN HALF WITH H. BANSHAW

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DIMENSIONS ARE IN INCHES		DRAWN	J.SIBERT	2/12/2015	CIMWD-110 Project 2
TOLERANCES:		CHECKED			
FRACTIONAL: ±		ENG APPR.			
ANGULAR: MACH ± BEND ±		MFG APPR.			
TWO PLACE DECIMAL ±		Q.A.			SIZE DWG. NO. REV
THREE PLACE DECIMAL ±		COMMENTS:			A PART 1 0
INTERPRET GEOMETRIC TOLERANCING PER:					SCALE: 1:2 WEIGHT: SHEET 1 OF 1
MATERIAL					
FINISH					
APPLICATION					
DO NOT SCALE DRAWING					

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