



Gas Tungsten Arc Welding (Steel and Stainless Steel-Flat and Horizontal)

Project 1 – Specification and Print

Weld Type	Square Groove
Welding Process	GTAW
Position	Flat
Material	1/8" Steel
Joint Type	Butt
Backing Option	PJP
Backing Material	

Polarity	DC+
Electrode	ER70s-6
Transfer Mode	
Tungsten Electrode	2% Ceriated
Shielding Gas	100% Argon
Flow Rate	25 cfh
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
Stringer	Butt	GTAW	ER-70s-6	1/16"	120a	DC+			





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Heat Treatment:

Preheat Temperature:

Post Heat Temperature:

Interpass Temperature: Quench after 2-3 passes

Stress Relieving:

Technique: Butt Joint single pass weld

Number of Electrodes: whatever it takes

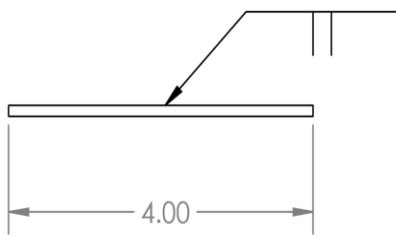
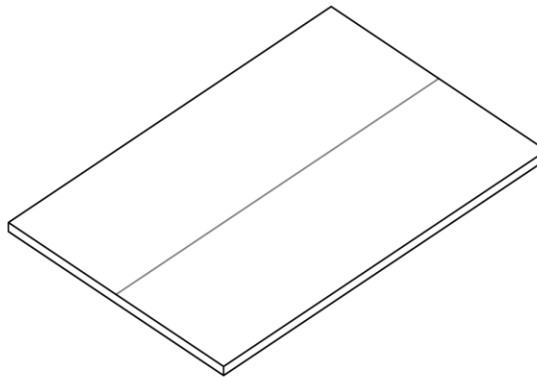
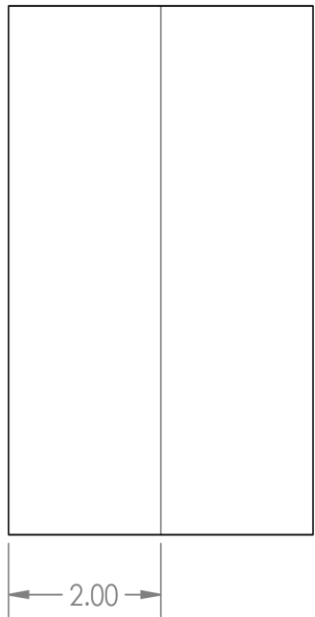
Additional Notes: Show instructor progress every 30 minutes, minimum.





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		UNLESS OTHERWISE SPECIFIED:		NAME	DATE	TITLE: CIMWD-121 Project 1
		DIMENSIONS ARE IN INCHES	DRAWN			
		TOLERANCES: FRACTIONAL ± ANGULAR: MACH ± BEND ± TWO PLACE DECIMAL ± THREE PLACE DECIMAL ±	CHECKED			
		INTERPRET GEOMETRIC TOLERANCING PER:	ENG APPR.			
		MATERIAL	MFG APPR.			SIZE DWG. NO. REV
		FINISH	Q.A.			A Part 9 1 8 line
		APPLICATION	COMMENTS:			SCALE: 1:2 WEIGHT: SHEET 1 OF 1
		DO NOT SCALE DRAWING				

5

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