



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

Project 4 – Specification and Print

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

Stress Relieving:

Technique: Butt Joint single pass weld

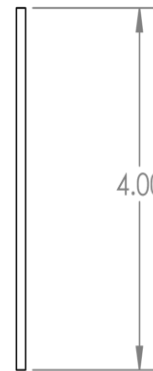
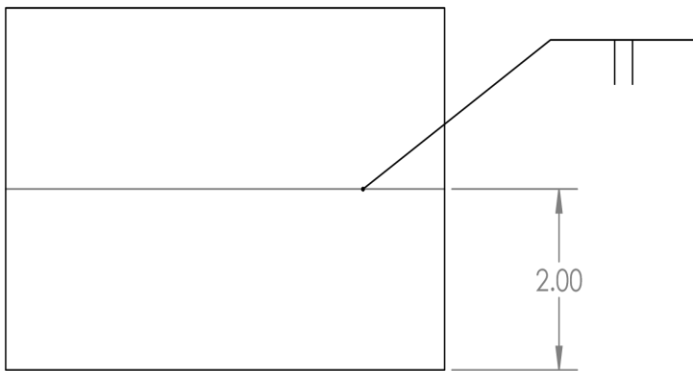
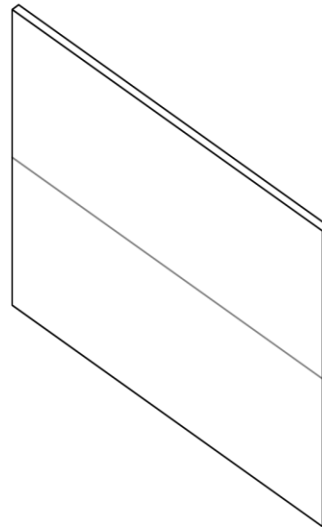
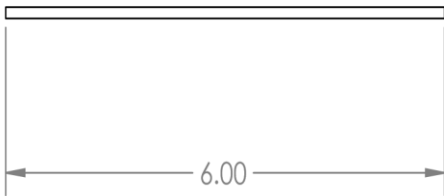
Additional Notes: Show instructor progress every 30 minutes, minimum.





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		UNLESS OTHERWISE SPECIFIED:	NAME	DATE	
		DIMENSIONS ARE IN INCHES	DRAWN		TITLE: CIMWD-121 Project 4
		TOLERANCES:	CHECKED		
		FRACTIONAL: ±	ENG APPR.		
		ANGULAR: MACH ± BEND ±	MFG APPR.		
		TWO PLACE DECIMAL ±	Q.A.		
		THREE PLACE DECIMAL ±	COMMENTS:		
		INTERPRET GEOMETRIC TOLERANCING PER:			SIZE DWG. NO. REV
		MATERIAL			Part A 1 8 line Horizontal
		FINISH			SCALE: 1:2 WEIGHT: SHEET 1 OF 1
		APPLICATION			
		DO NOT SCALE DRAWING			

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