



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

Project 6 – Specification and Print

Weld Type	Fillet
Welding Process	GTAW
Position	Horizontal
Material	1/8" Stainless Steel
Joint Type	Lap
Backing Option	
Backing Material	

Polarity	DC+
Electrode	308
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	Lap	GTAW	308	1/16"	75a	DC+			





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Heat Treatment:

Preheat Temperature:

Post Heat Temperature:

Interpass Temperature:

Stress Relieving:

Technique: Butt Joint single pass weld

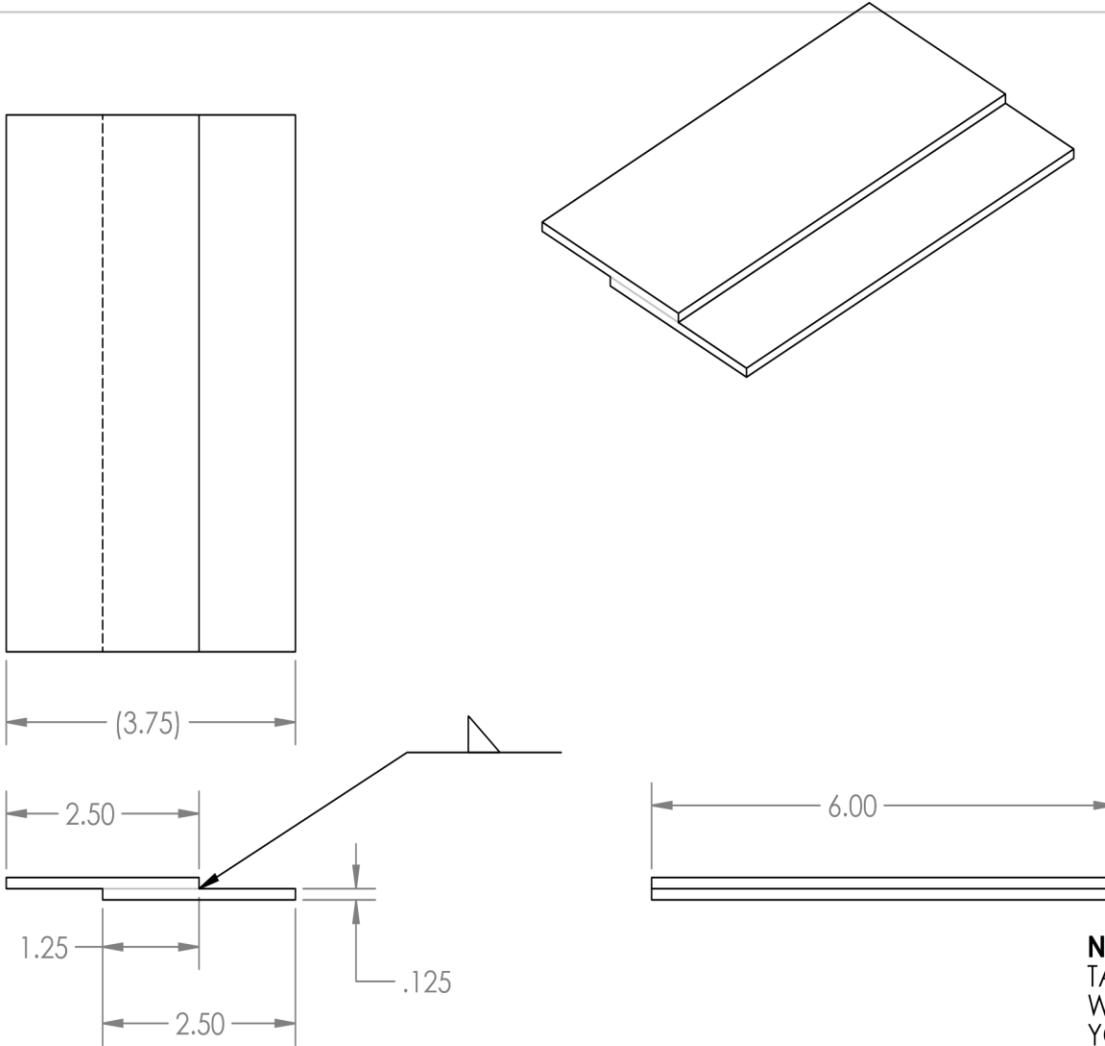
Additional Notes: Show instructor progress every 30 minutes minimum.





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NOTE: SHEAR CUT
TACK WITH GMAW
WELDED IN MODULE
YOU ARE PARTICIPATING IN NEXT

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		UNLESS OTHERWISE SPECIFIED:	NAME	DATE	
		DIMENSIONS ARE IN INCHES	DRAWN		TITLE: CIMWD-121 Project 6
		TOLERANCES:	CHECKED		
		FRACTIONAL ±	ENG APPR.		
		ANGULAR: MACH ± BEND ±	MFG APPR.		
		TWO PLACE DECIMAL ±	Q.A.		
		THREE PLACE DECIMAL ±	COMMENTS:		SIZE DWG. NO. REV
		INTERPRET GEOMETRIC TOLERANCING PER:			A PART 7
		MATERIAL			SCALE: 1:2 WEIGHT: SHEET 1 OF 1
		FINISH			
	USED ON	DO NOT SCALE DRAWING			
	APPLICATION				

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4

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