



Gas Tungsten Arc Welding (Steel and Stainless Steel-Vertical)

Project 1 – Specification and Print

Weld Type	Square Groove
Welding Process	GTAW
Position	Vertical
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:

Stress Relieving:

Technique: Butt Joint single pass weld in vertical up

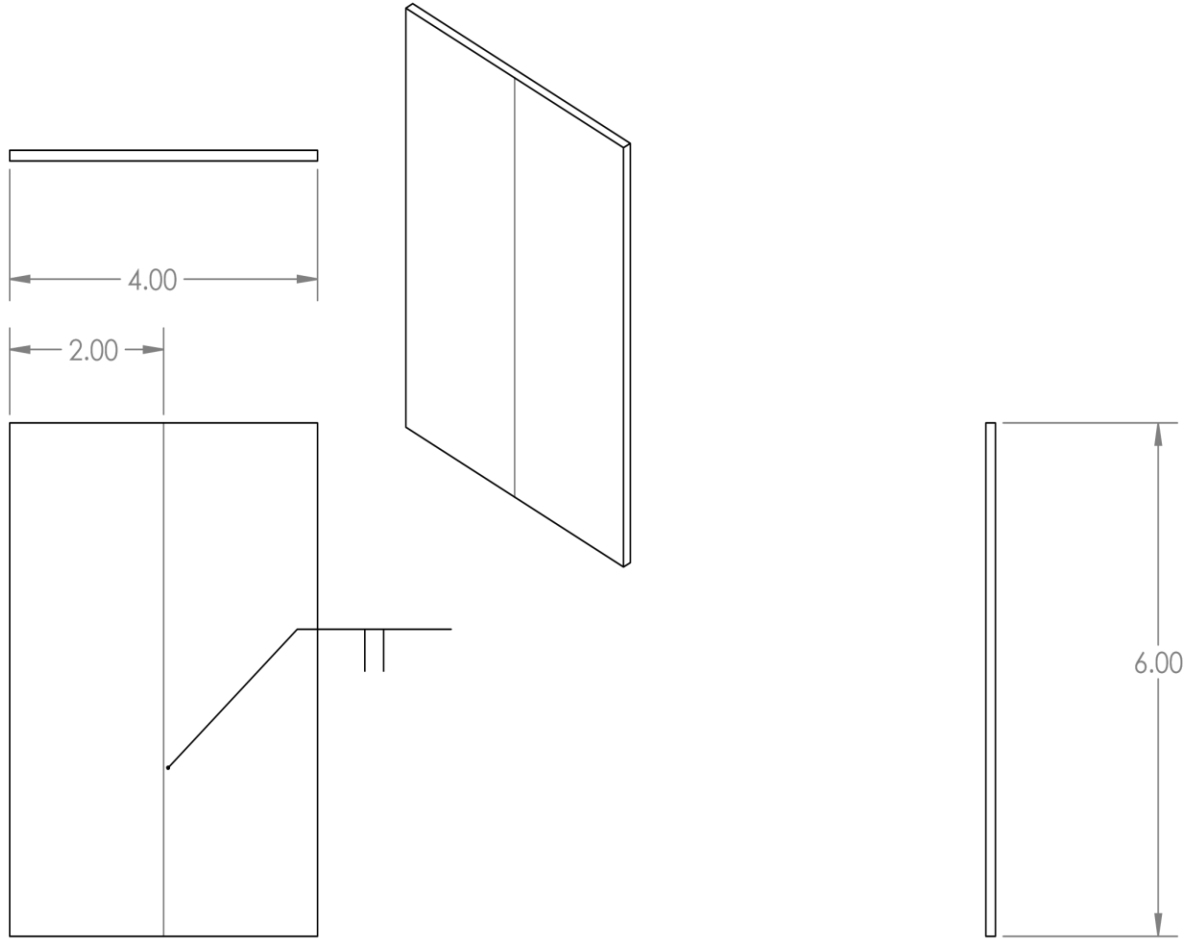
Additional Notes: Show instructor progress every 30 minutes, minimum.





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		UNLESS OTHERWISE SPECIFIED:	NAME	DATE	TITLE: CIMWD-122 Project 1
		DIMENSIONS ARE IN INCHES	DRAWN		
		TOLERANCES:	CHECKED		
		FRACTIONAL ±	ENG APPR.		
		ANGULAR: MACH ± BEND ±	MFG APPR.		
		TWO PLACE DECIMAL ±	Q.A.		SIZE DWG. NO. REV
		THREE PLACE DECIMAL ±	COMMENTS:		Part 9 1 8 line Vert
		INTERPRET GEOMETRIC TOLERANCING PER:			SCALE: 1:2 WEIGHT: SHEET 1 OF 1
		MATERIAL			
		FINISH			
APPLICATION	USED ON	DO NOT SCALE DRAWING			

5

4

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1





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