



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

Project 3 – Specification and Print

Weld Type	Fillet
Welding Process	GTAW
Position	Vertical
Material	1/8" Steel
Joint Type	Tee
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	Tee	GTAW	ER-70s-6	1/16"	120a	DC+			





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Heat Treatment:

Preheat Temperature:

Post Heat Temperature:

Interpass Temperature:

Stress Relieving:

Technique: Tee Joint single pass weld in vertical up

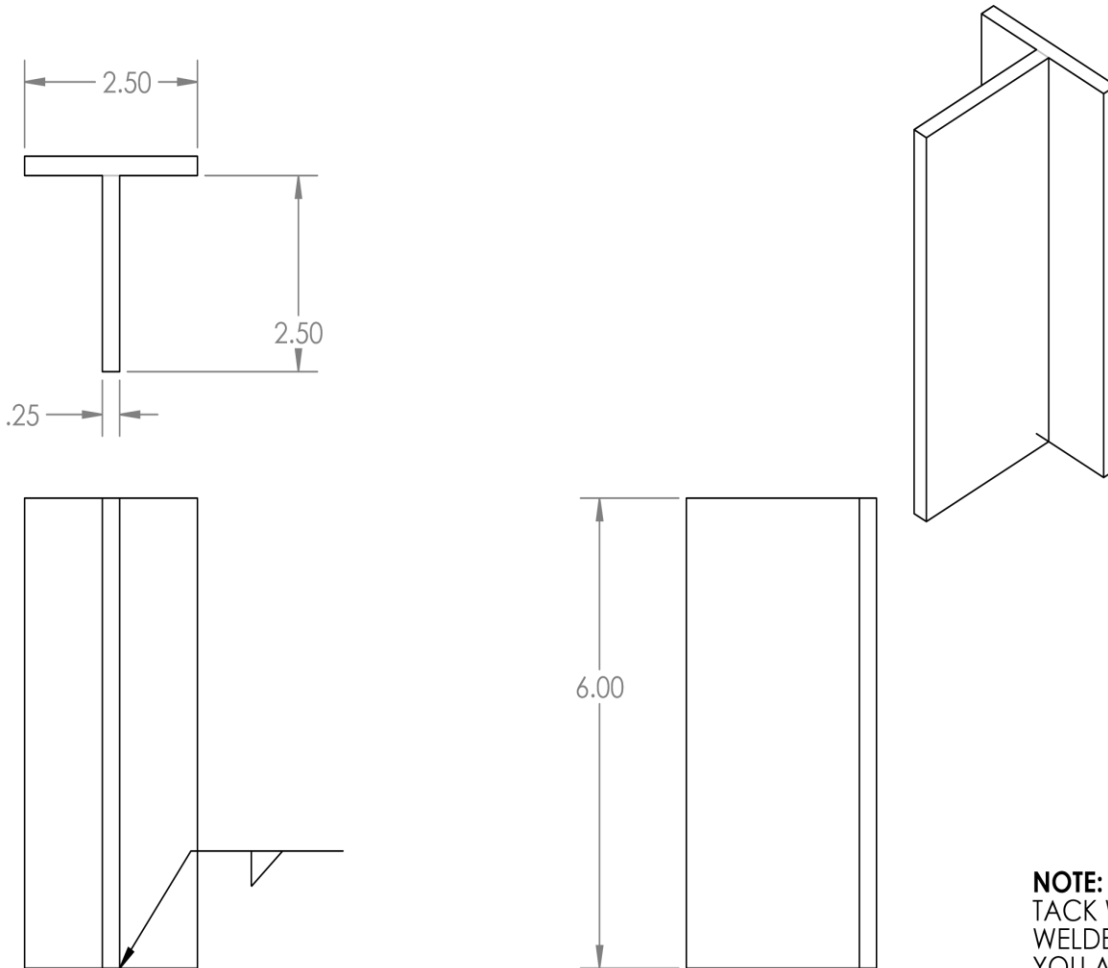
Additional Notes: Show instructor progress every 30 minutes, minimum.





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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	J.SIBERT	2/19/2015	TITLE: CIMWD-122 Project 3
		TOLERANCES:		CHECKED			
		FRACTIONAL: ±		ENG APPR.			
		ANGULAR: MACH ± BEND ±		MFG APPR.			
		TWO PLACE DECIMAL ±		Q.A.			SIZE DWG. NO. REV A PART 8 0
		THREE PLACE DECIMAL ±		COMMENTS:			
		INTERPRET GEOMETRIC TOLERANCING PER:					SCALE: 1:2 WEIGHT: SHEET 1 OF 1
		MATERIAL					
		FINISH					
		APPLICATION					
		DO NOT SCALE DRAWING					

5

4

3

2

1





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